

Date:
User:Wednesday, 3/7/2007 4:28:07 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY LH/ DSI 9335
Job Number	: 31080		
Estimate Number	: 12775		
P.O. Number	: N/A	Part Number	: D350600241
This Issue	: 3/7/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3188,ICA
First Issue	: 3/7/2007	Project Number	: N/A
Previous Run	: 31078	Drawing Revision	: C
		Material	: N/A
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:A 07.03.07 new issue ec		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

K8 07.03.16 ①

2.0 31080A SWITCH RELOCATION KIT



D350-600-449



Comment: Sub-Component SWITCH RELOCATION KIT

B31083A

3.0 31080B SPACEPOD BODY LH



D3188-1 m



Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: _____

w/o 30027

ml 07/03/26

4.0 31080C SPACEPOD DOOR LH



D3186-1 m



Comment: Sub-Component SPACEPOD DOOR LH

w/o 30017

ml 07/03/26

5.0 D31871 Spacepod Floor

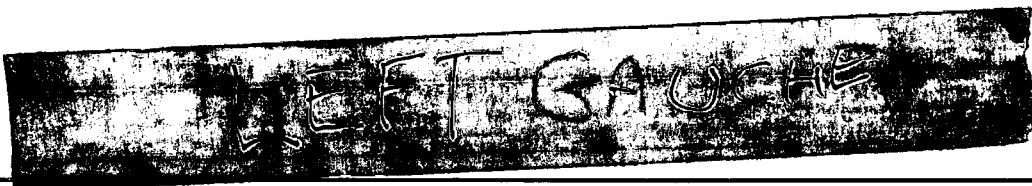


Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-1	Floor	B25404
1	D3186-3	Door (ref)	N/A
1	D3188-1	Body(ref)	N/A

ml 07/03/28 ✓



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

ALS41032130

AE LS -1032-130

Insert



as QSI



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: *M102776 X 28*

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-1

ml 07/03/28

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/28 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-1 floor only*****

Chemical Conversion Coat as per QSI 005 4.1

FL

07/03/28 ①

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****D3187-1 floor only*****

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL

07/03/28 ①

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/03/28

W/O:		WORK ORDER CHANGES					
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Job Number: 31080

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CE W/A

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch: B24628

ml 07/03/28

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml 07/03/28

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M102565 ml 07/03/28

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CE W/A

16.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Label
batch: B31116

17.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B30169

18.0

D35471

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: B30636

67/03/28 50

W/O:		WORK ORDER CHANGES					
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Job Number: 31080

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
STRUT
batch: B31148

20.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD
batch: B50210

21.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DECAL
batch: M31128

22.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: B30680
Batch: B30680

23.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: M4067
Batch: M4067

24.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
HINGE BRACKET
batch: B31123

25.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: B21490
Batch: B21490

7/03/28

SD

W/O:		WORK ORDER CHANGES					
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Job Number: 31080

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M103574

27.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M102842

28.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M103538

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-1 floor with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for body & floor*

M107/03/28

30.0

D35527

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B30638

31.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103595

32.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M102842

07/03/28 SQ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31080

Part Number: D350600241

Job Number:



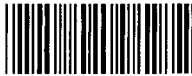
Seq. #:	Machine Or Operation:	Description :
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33.0	NAS1515H3	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: 100993

34.0	MS21042L08	Nut
------	------------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: 1103539

35.0	D2464	3/4 Seal
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Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s) (11)
3/4 Seal
Cut 127.00" long batch: 133068

36.0	D35671	DECAL
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DECAL
batch: 7131107

37.0	D2586	Door Latch
------	-------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Door Latch
batch: 1329021

38.0	D2585	Latch Clamp
------	-------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Clamp
batch: 1330814

39.0	D2621	Latch Plate
------	-------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Plate
batch: 132595

07/03/27 CD

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 31080

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M/8057

41.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: M/0344

42.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: M/02658

43.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: B29051

44.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: B29022

45.0

D2228

Backing Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
* Backing Plate
batch: B31237 x4

46.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
batch: M/03385

07/03/2005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31080

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
batch: M102842

48.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut
batch: M103536

49.0

D35571

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: B30644

50.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD
batch: B30210

51.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Washer
batch: M102519

52.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B30119

53.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M9216

67/03/27 S9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31080

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585

07/03/28 59

55.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

PTO
mlo 07/03/29

56.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-30

57.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M10 3480

mlo 07/03/29

58.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

SB 07/03/30

59.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

B31/30

7/3/30

60.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W 07-03-30

61.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-241

Location: A

PPP Rev: A

7/3/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/03/29	55	Because the drw. these parts missed on w/o Need Hypol 934 <u>M103922</u> milled filer <u>M100859</u> (10% weight) <i>Permanent change</i>	<i>ml</i>	07/03/29	1/R	<i>[Signature]</i> 07-03-20	<i>[Signature]</i> 07-03-30

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31080

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

62.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
707103130

Job Completion



U 707103.30

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

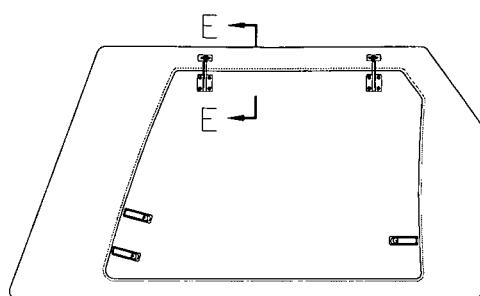


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

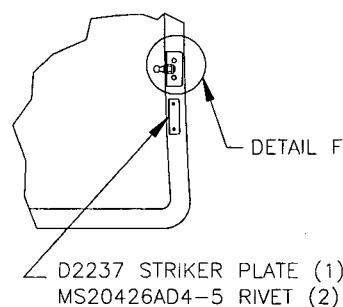


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

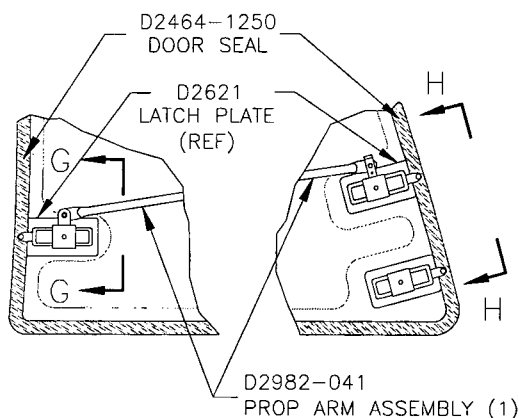
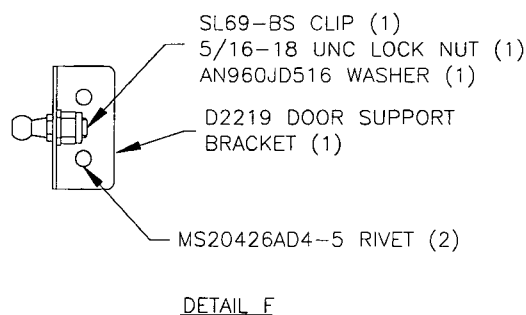


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



DETAIL F

TC Accepted

MAY 07 2003

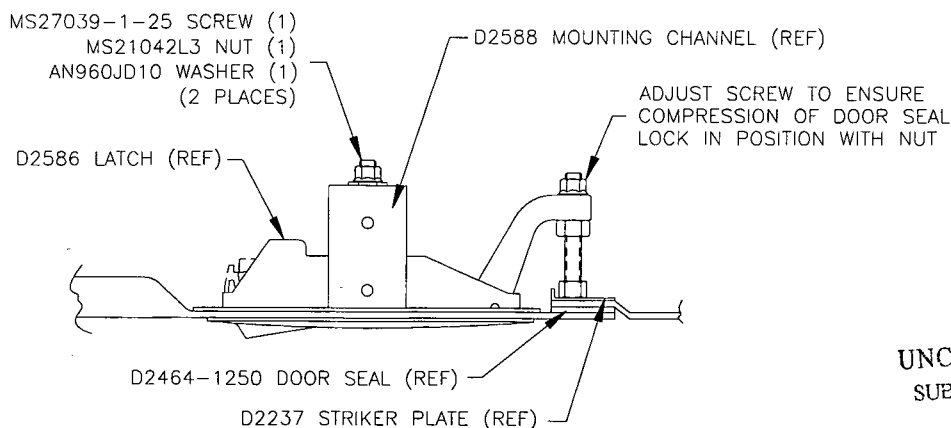
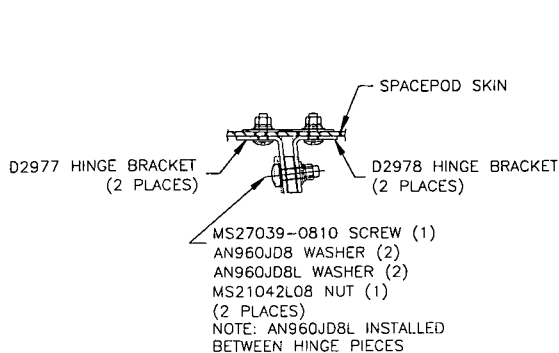


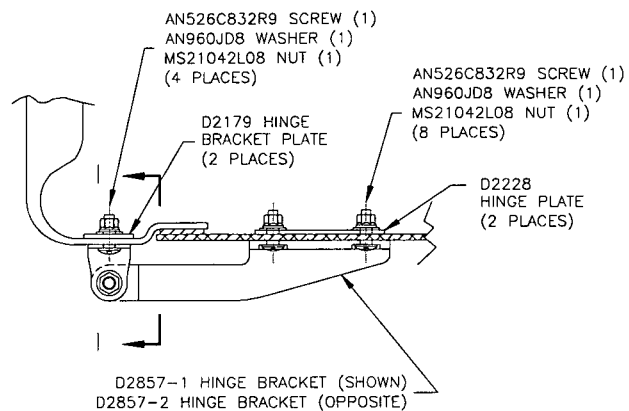
FIGURE 6. TYPICAL LATCH INSTALLATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31080

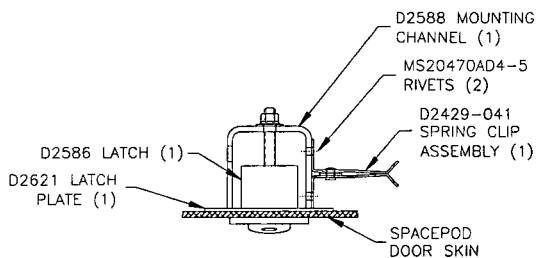
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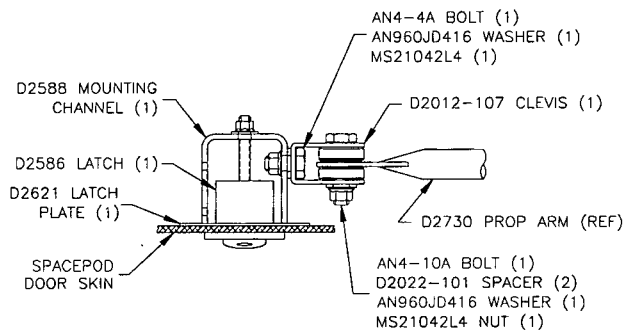
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31080

TC Accepted
MAY 07 2003

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07.02.22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	LC		
CHECKED	APPROVED	DRAWING NO.	REV. D
JB	LC	D3188	SHEET 1 OF 11
DATE		TITLE	SCALE
07.02.22		SPACEPOD BODY	NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SCHEDULE:

PARTD3188-1M/-1/-5
D3188-2M/-2/-6
D3188-3M/-3/-7LAYUPDT8003
DT8004
DT8500TRIM AND DRILLDT8501
DT8502
DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

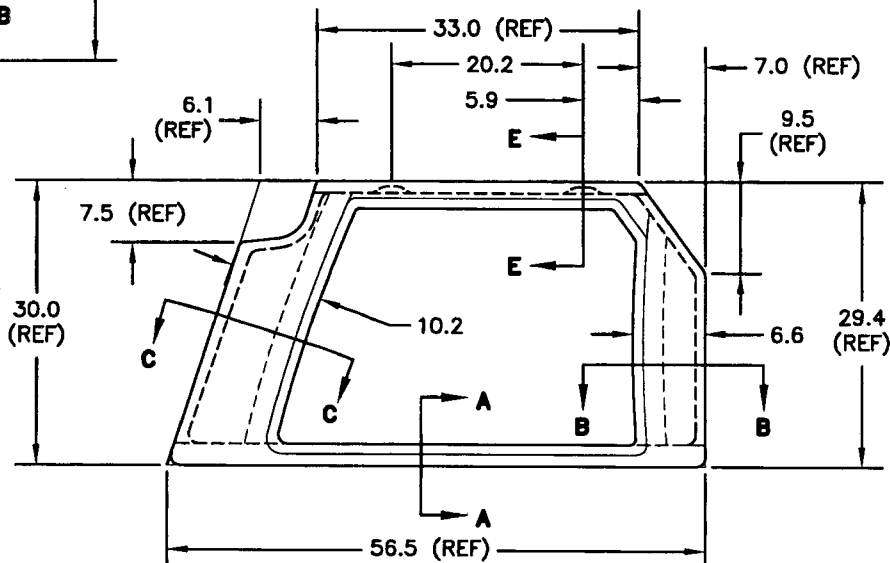
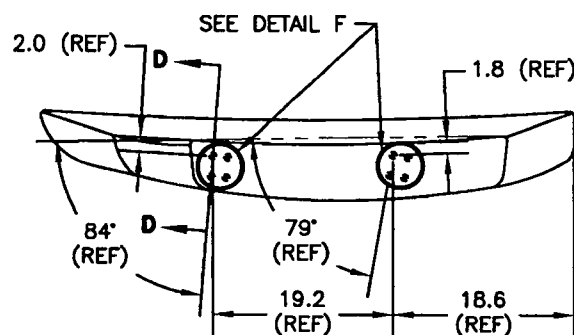
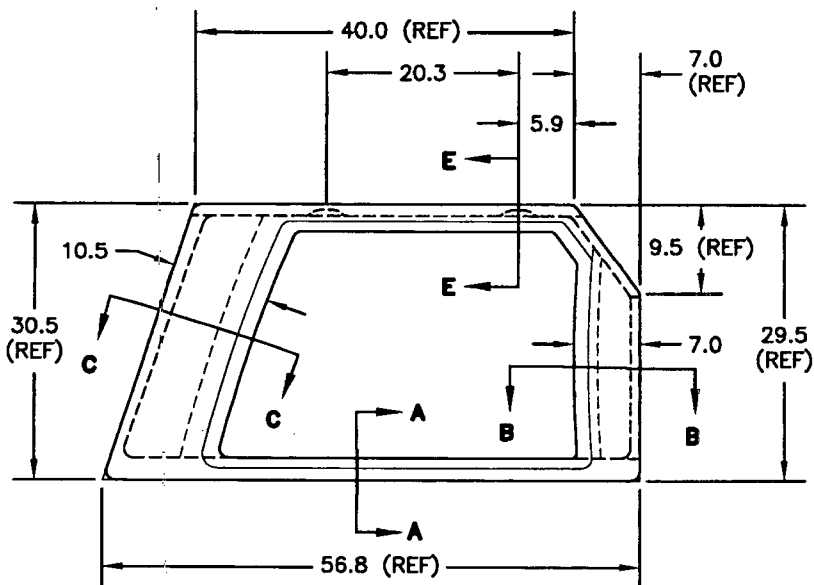
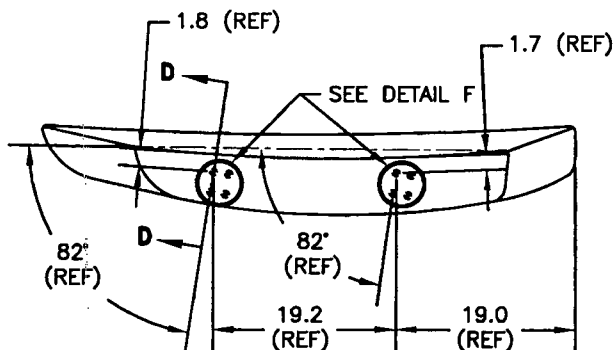
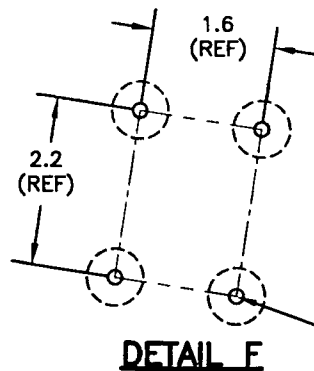
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY

D3186-1M/-3M NOTES:

1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.

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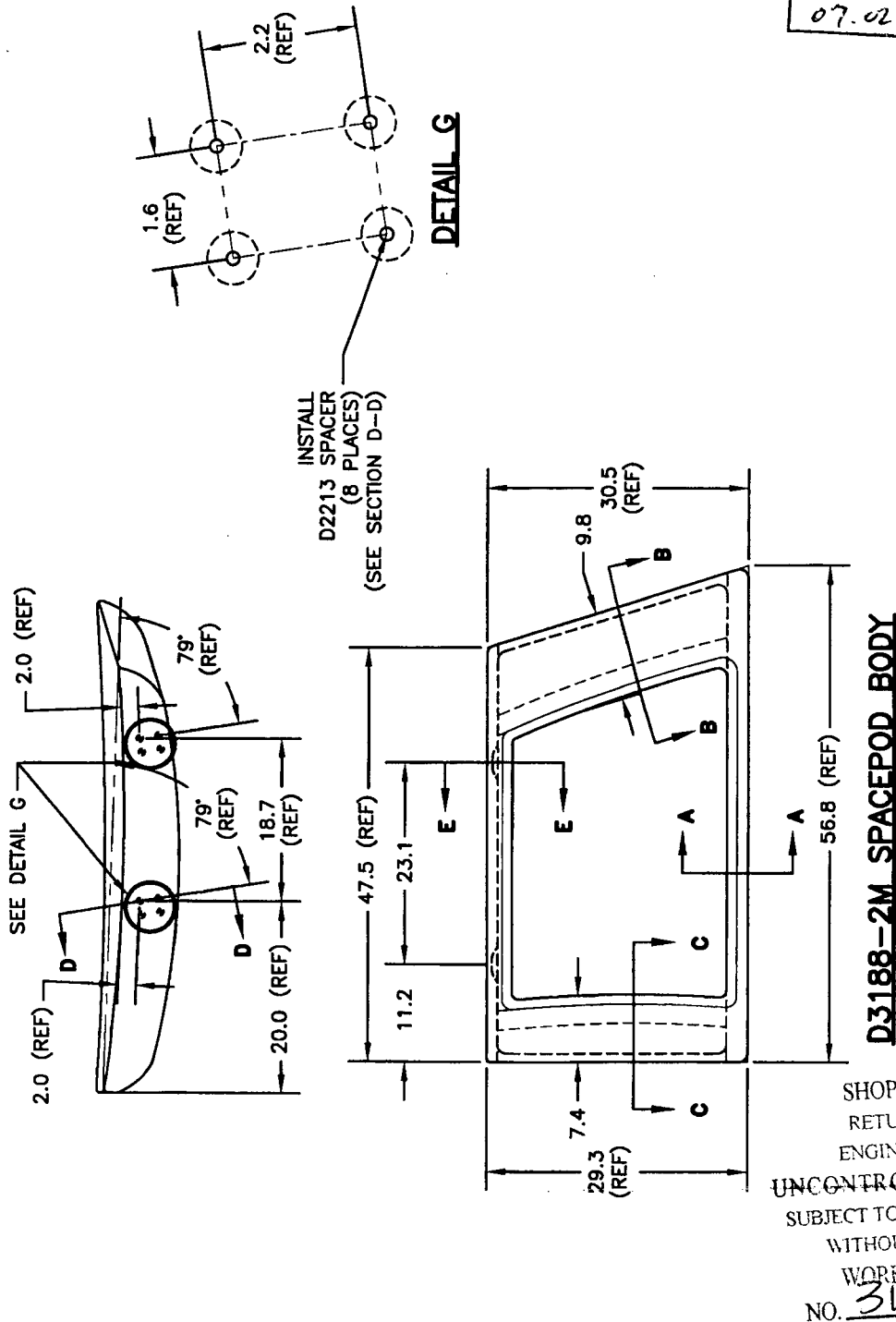
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CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.02.22	DRAWING NO.	D3188	REV. D
TITLE	SPACEPOD BODY	SHEET	2 OF 11	SCALE
		NTS		



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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

RELEASED
07.02.27



D3186-2M NOTES:
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2. SEE SHEET #4 FOR SECTION VIEWS.

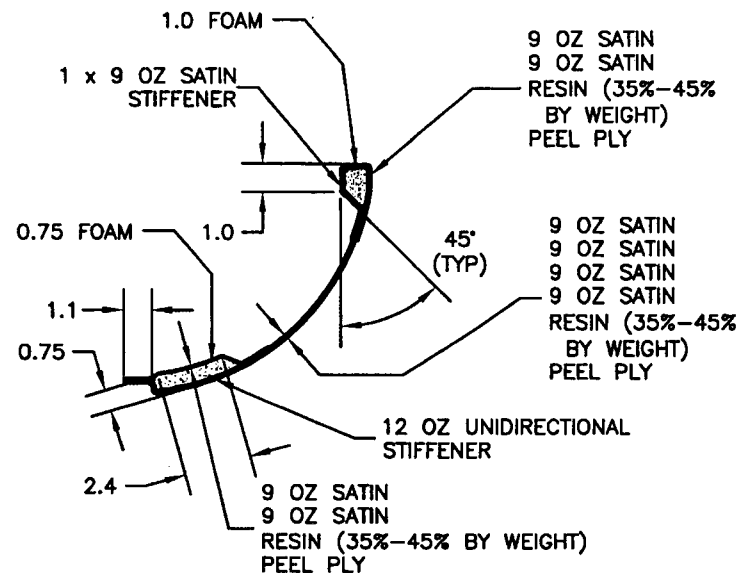
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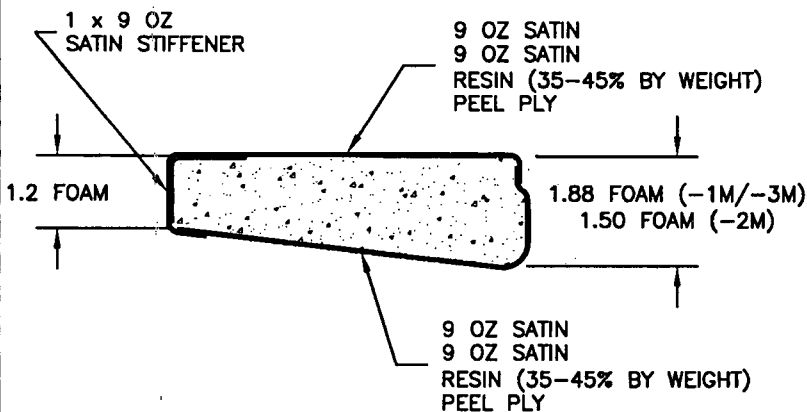
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		TITLE	SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

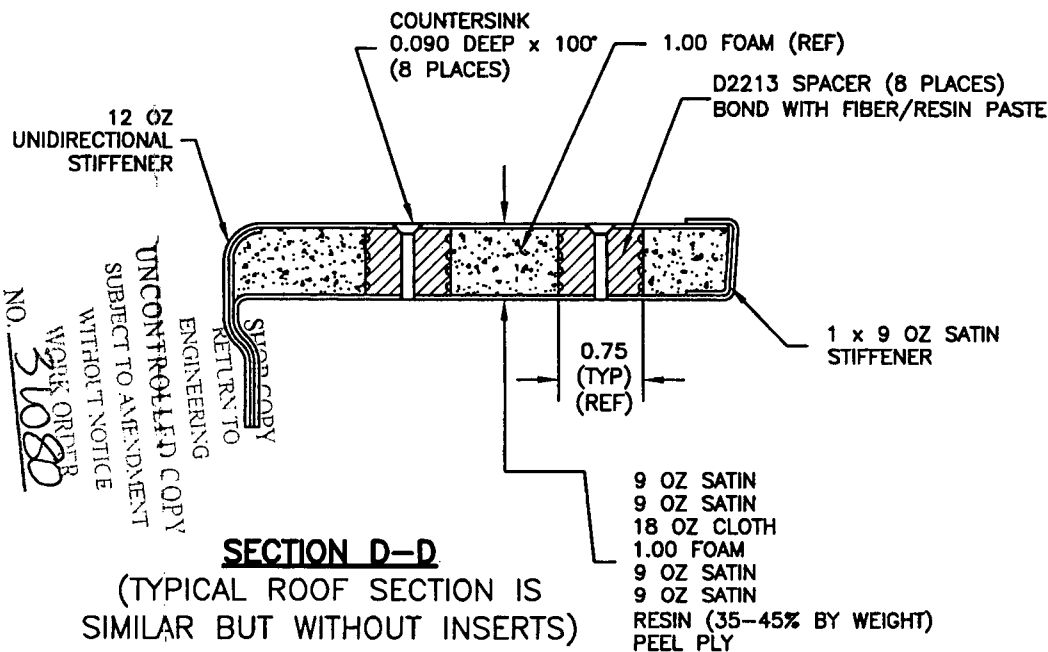
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07.02.22



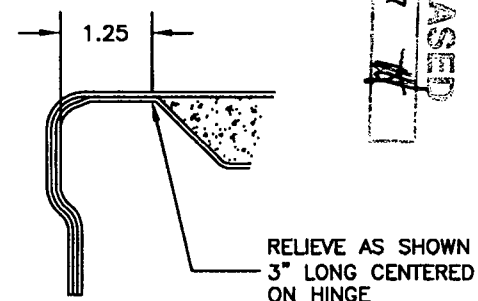
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

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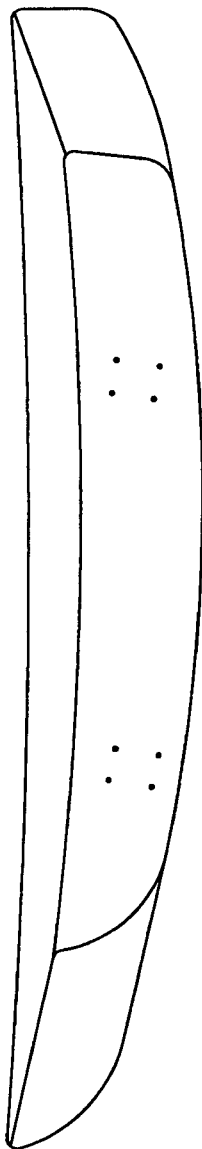
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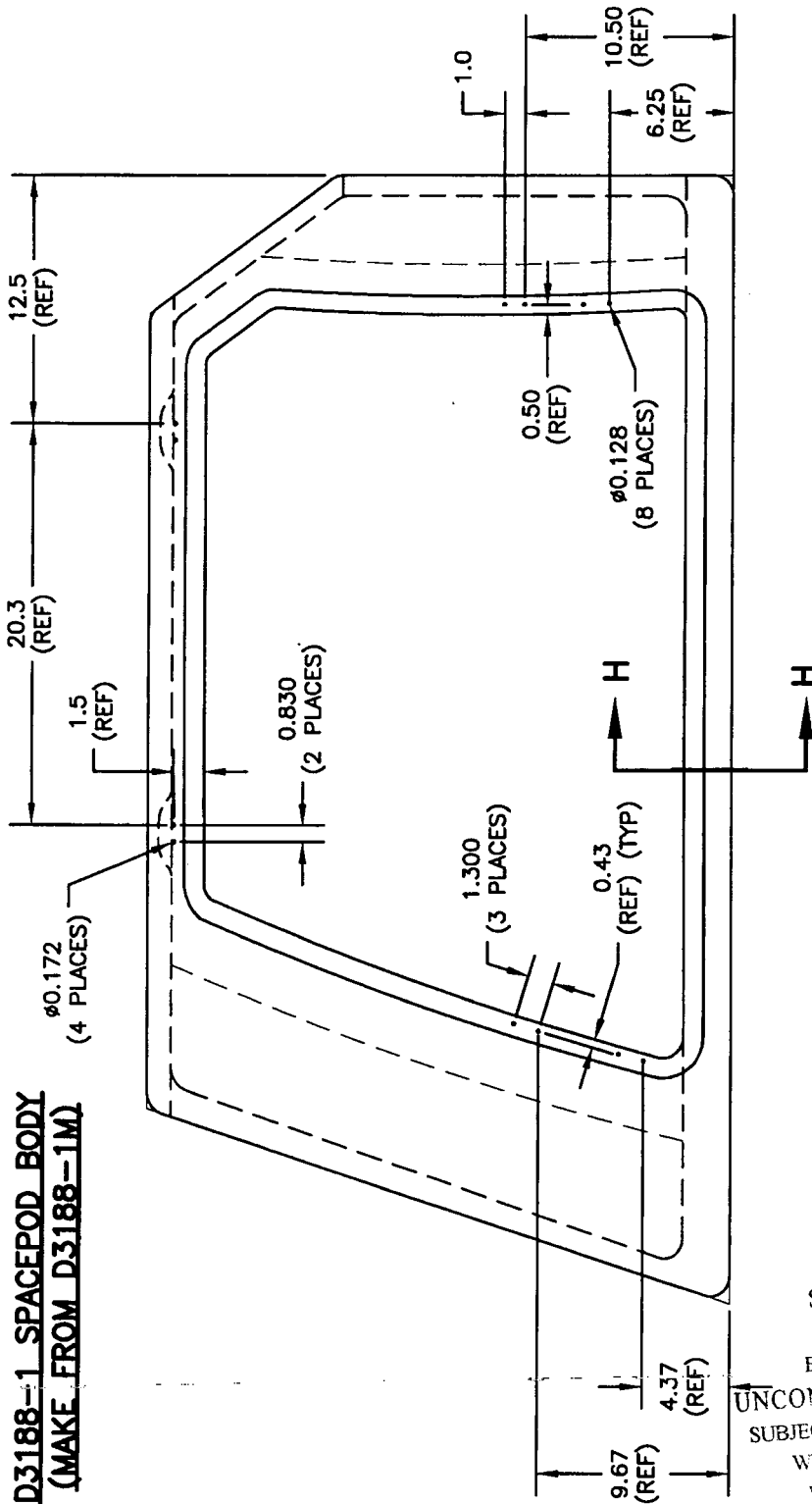


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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07-02-27 [Signature]



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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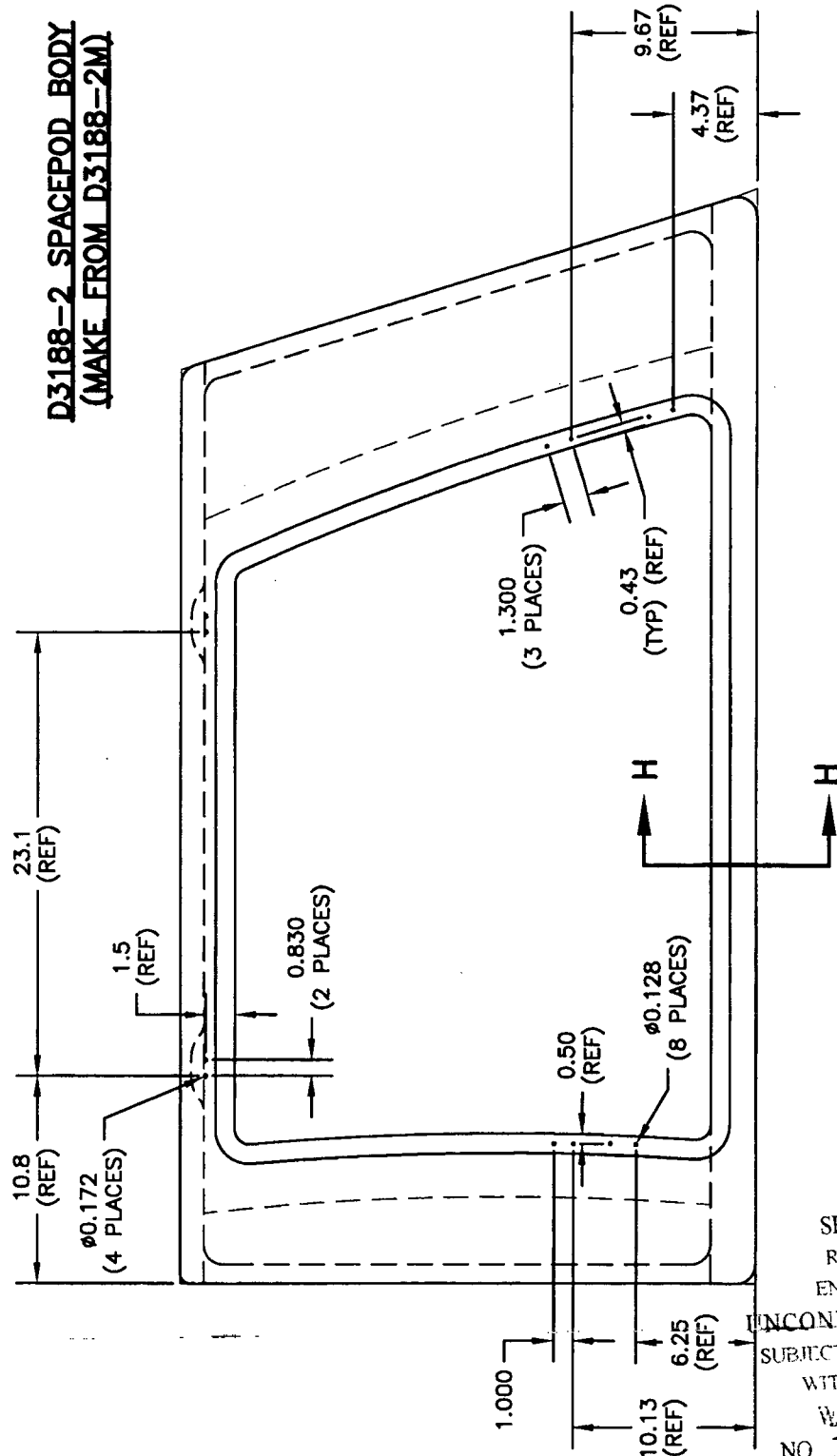
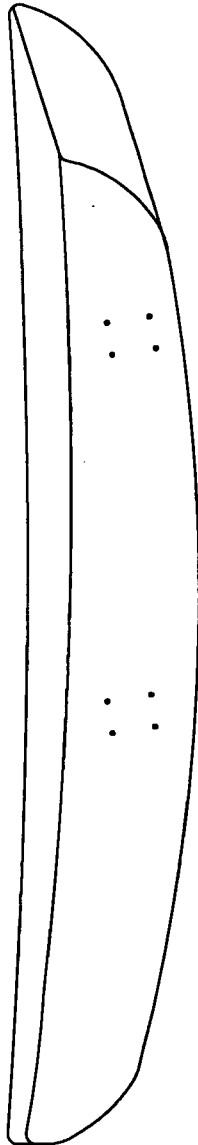
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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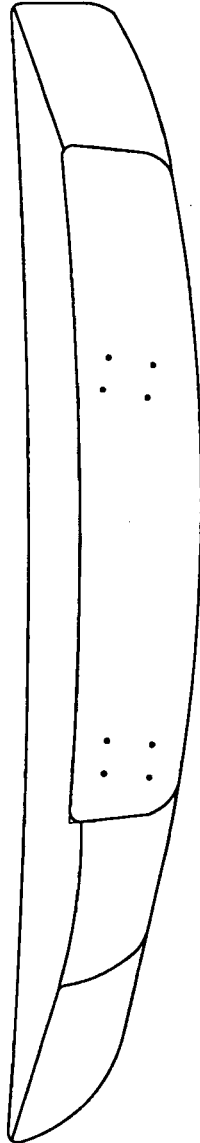
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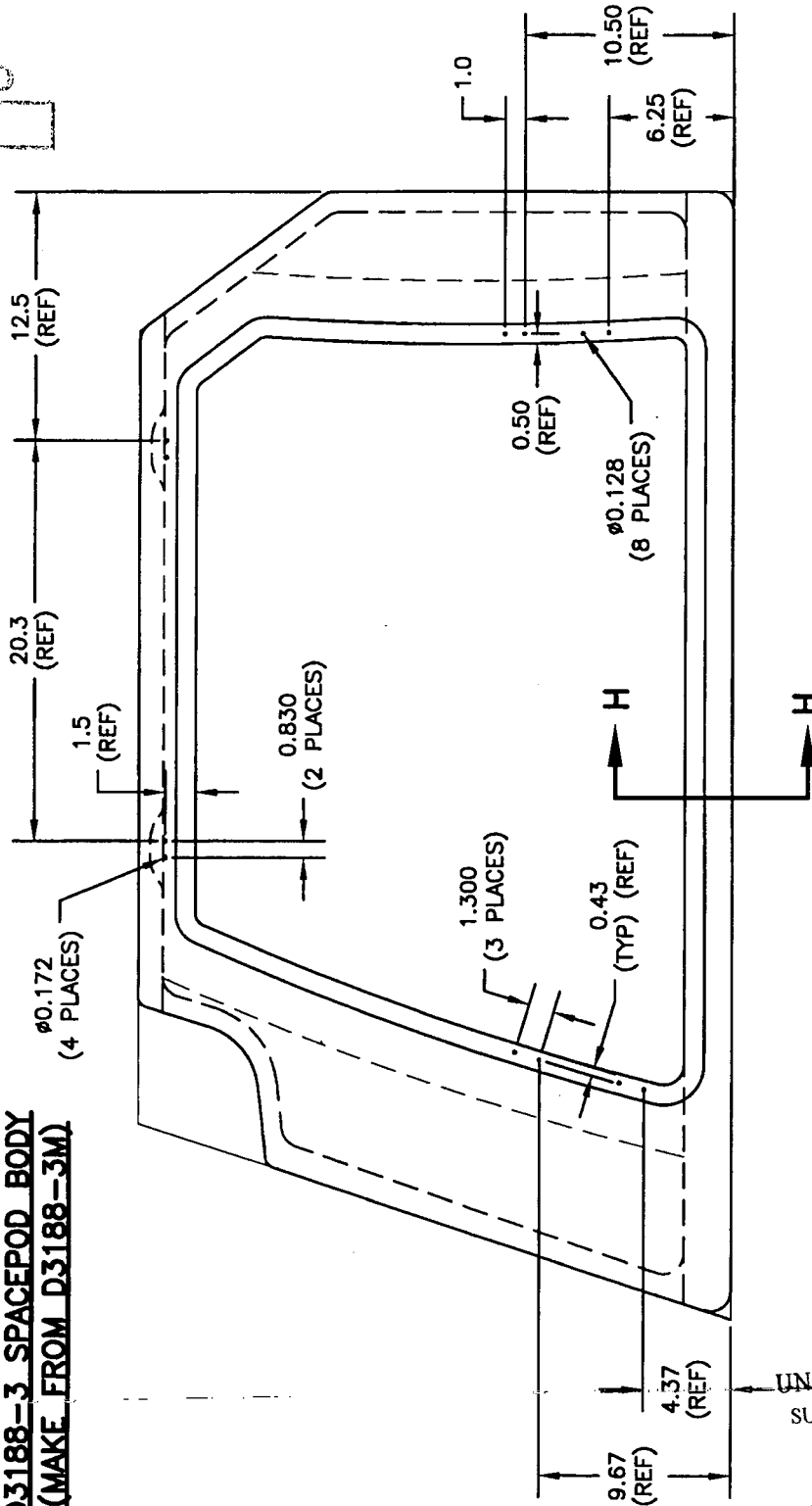
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07.02.27 [Signature]



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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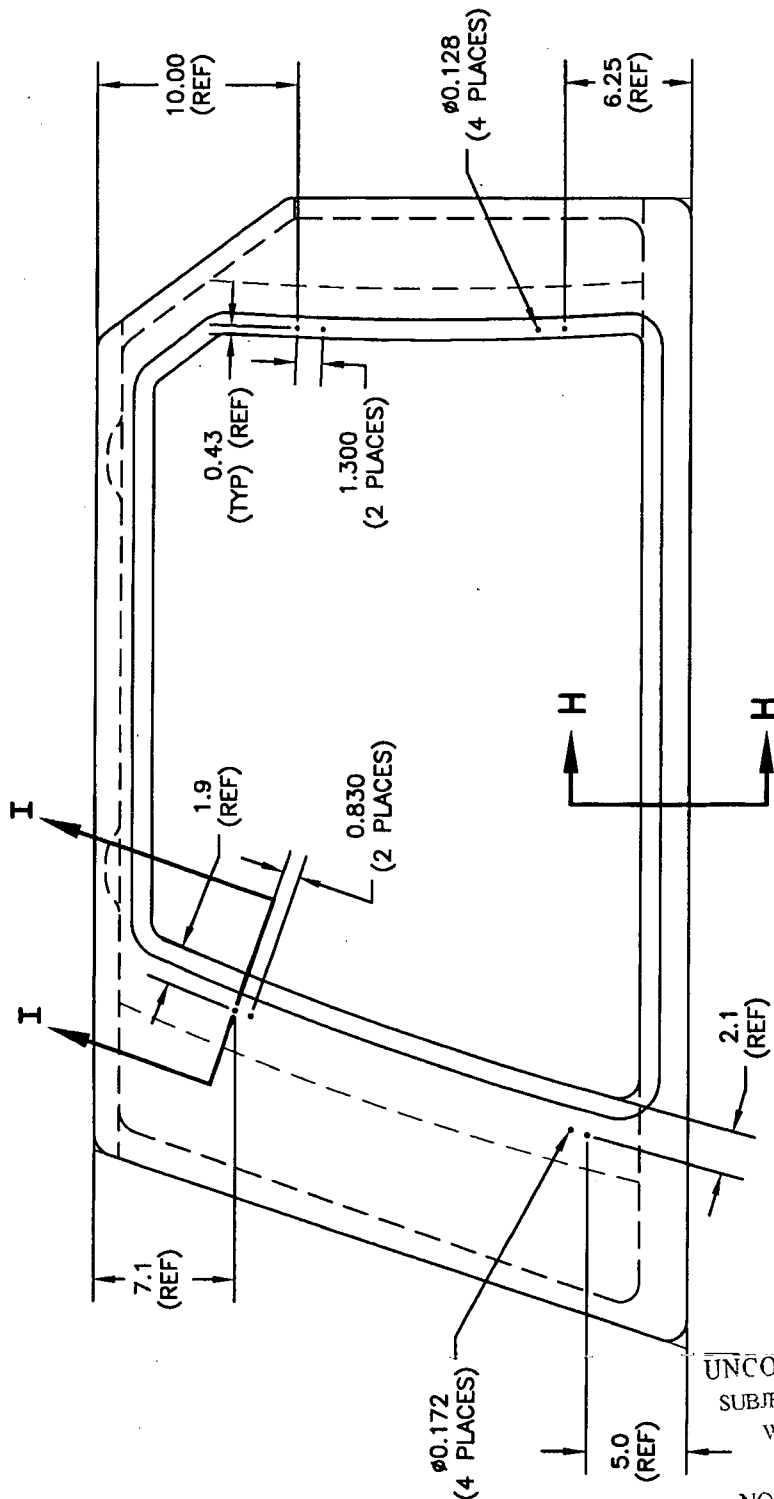
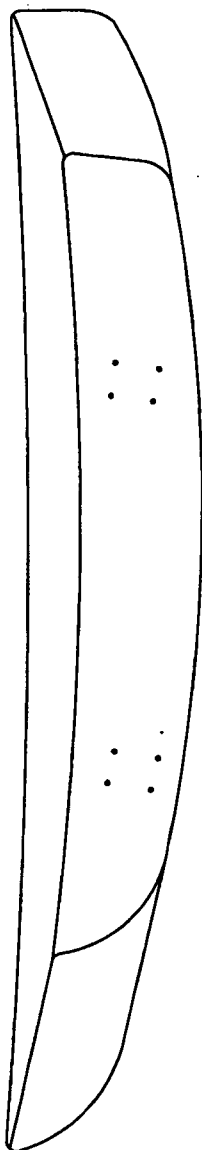


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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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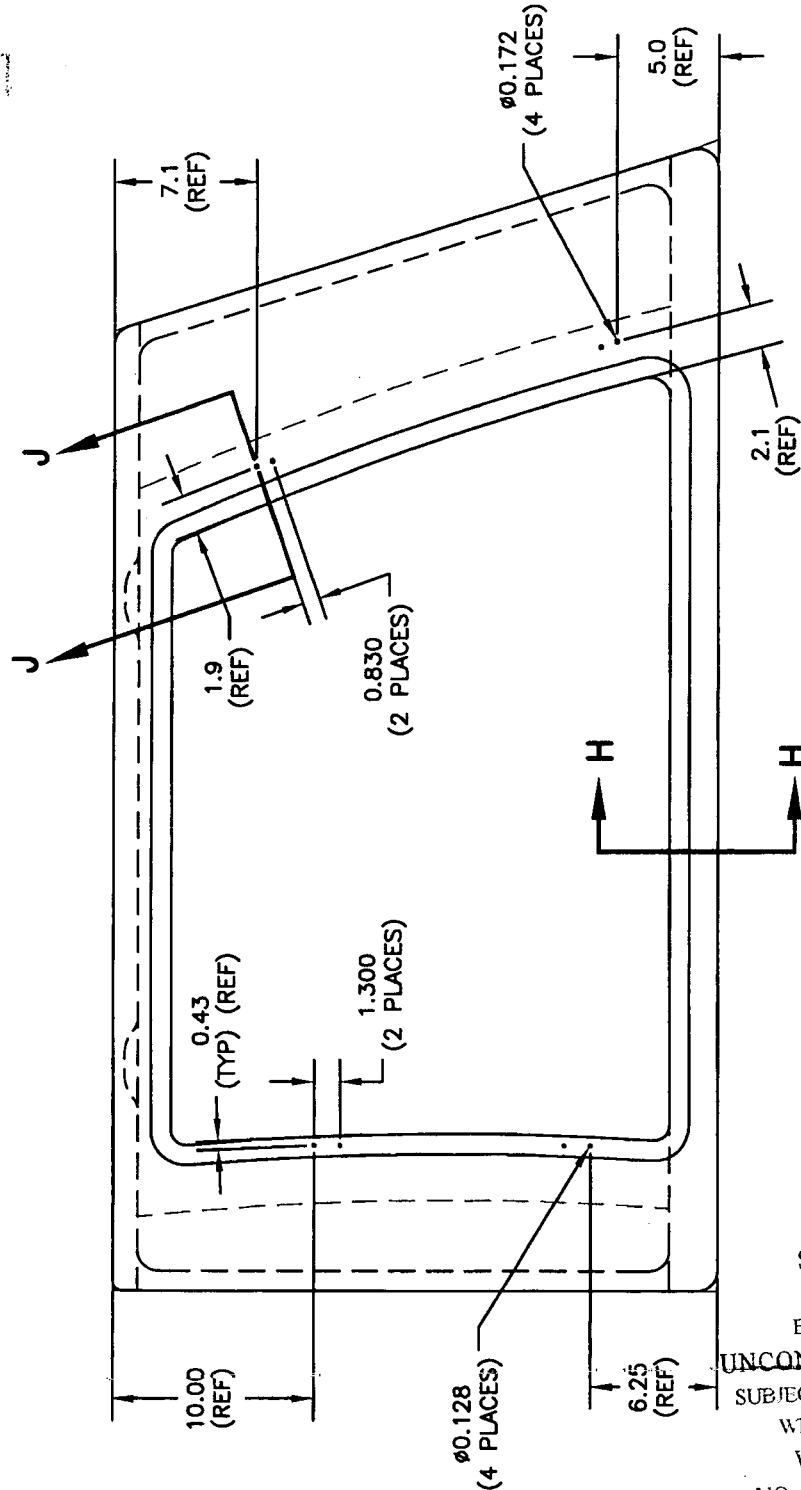
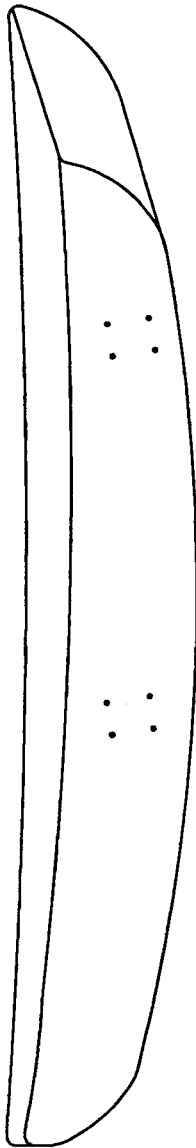
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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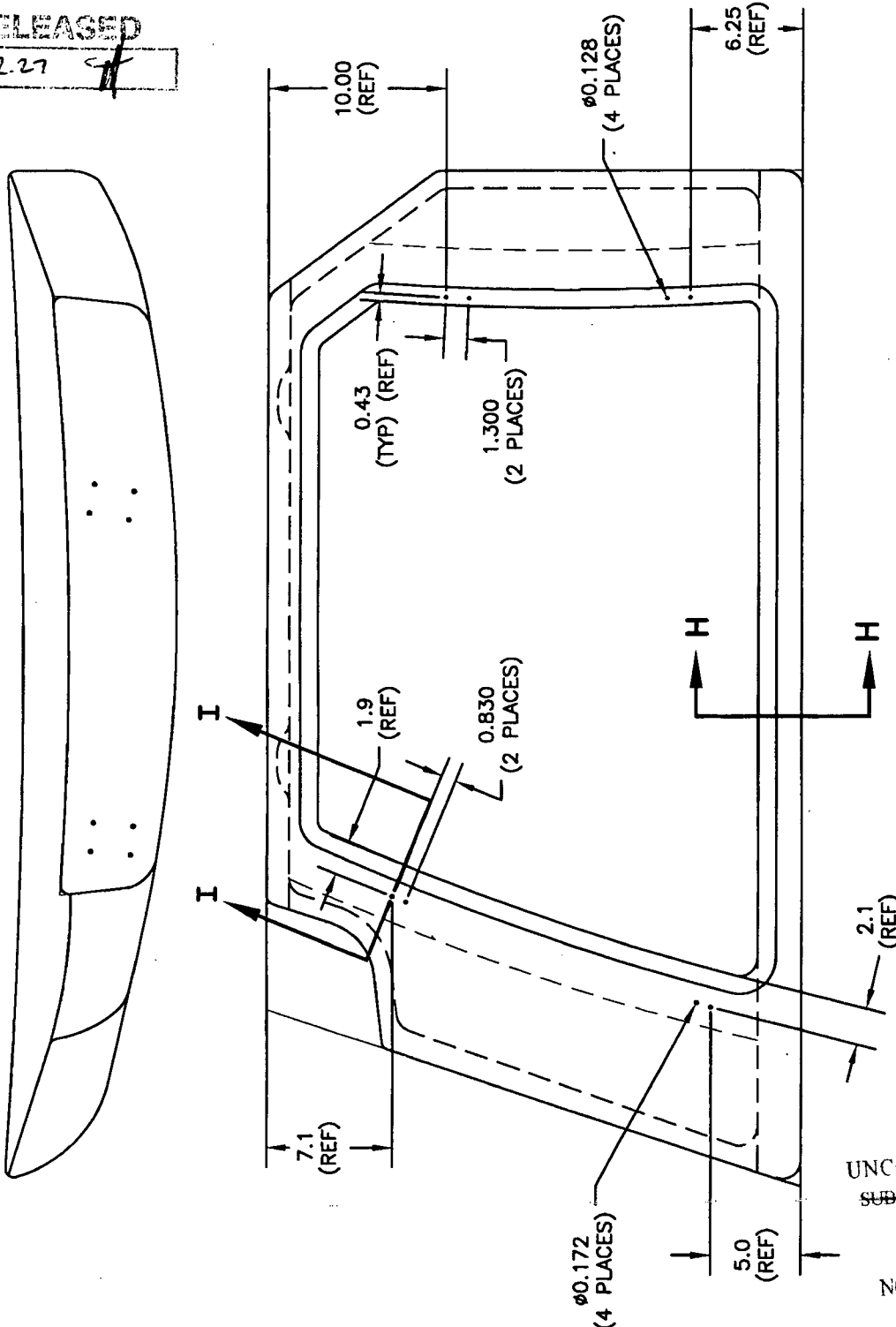
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07.02.22

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

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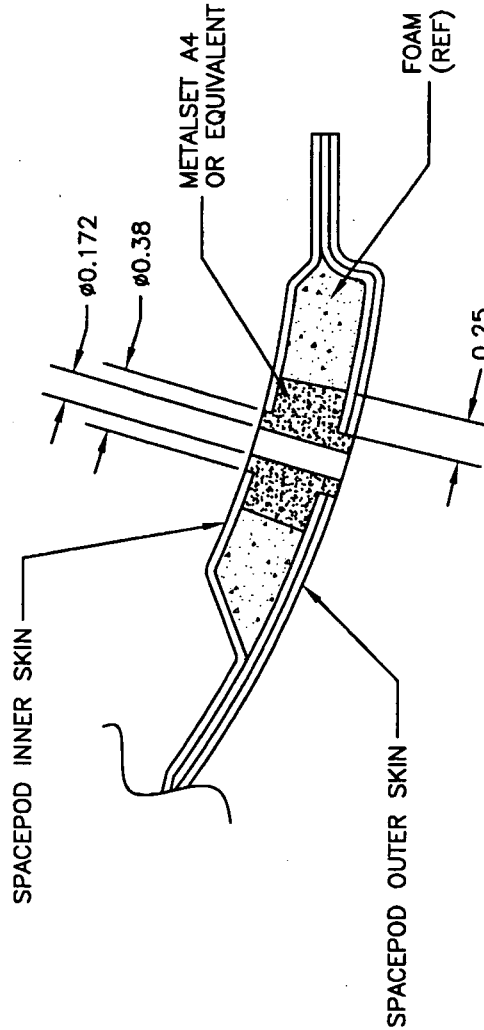
07.02.27 [Signature]

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11734
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336


Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #		GST/PST #
16/03/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30017 Dwg. Rév.: C JOB: 41109 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30027 Dwg. Rév.: C JOB: 40967 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

 16/3/07
Quality department AQ-357



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11734
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #		GST/PST #
16/03/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	✓ 1	DKC134-0052	D3186-1M Spacepod Door LH B30017 Dwg. Rév.: C JOB: 41109 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30027 Dwg. Rév.: C JOB: 40967 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

16/3/07

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Quality department AQ-357

Date: Mardi, 2007-03-06 09:14:14
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD DOOR	
Numéro Job	: 41109		Numéro Article	: DKC134-0052	
Numéro Soumission	: 2584		Numéro Dessin	: D3186	
Numéro B.A.	:		Projet Numéro	: DKC134	
Cette fois	: 2007-03-06	No. B.V. :	Révision dessin	: C	
Prsht Rev.	: NC		Matériel	: Fibre 7781 et Résine 411-350	
Prem. fois	: - -	Type :	Date Dûe	: 2007-03-09	Qté: 1 Udm: UNITE
Job précédente	: 41097				
Écrit par	:				
Vérifié & Approuvé par	:				
Commentaires	:	N° de pièce Dart Aerospace : D31861M			

Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.040 GALLON(s)
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 6/03/07 Heure Début: _____ Heure Fin: _____ Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 6.56 VERGE(s)
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 7.18 VERGE(s)
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41109

Nom Dessin: SPACEPOD DQOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total : 9.000 VERGE(s)
9.7 oz Weave #FG-778150-125Y Volan Finish

1-5905-1

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total : 4.5000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 2.00 VERGE CAR(s)
Fiberglass 12 oz Unidirectional N° de Lot: 5455

10.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 1.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 2/03/06 Heure Début: _____ Heure Fin: _____ Sceau:

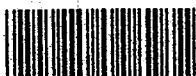
11.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0080 PINTE(s)/Unit Total : 0.0160 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 5921

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6015-1

13.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 6/03/07 Heure Début: _____ Heure Fin: _____ Sceau:

Date: Mardi, 2007-03-06 09:14:14
Utilisateur: Sylvie Hamel

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 41109

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

14.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 6/03/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



15.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 6/03/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: _____ Curing Fin: _____

16.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0120 PINTE(s)/Unit Total : 0.0240 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

17.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.600 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6015-1

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41109

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: 6/03/07

Heure Début:

Heure Fin:

Sceau:



19.0 DKC134-0056 Foam Core N° D3186-101 (Porte D3186-1)

Commentair Qty.: 1 UNITE(s)/Unit Total : 2 UNITE(s)
Foam Core N° D3186-101 (Porte D3186-1)

1-5826-1

20.0 AAC0452 Polybond B46F

Commentair Qty.: 0.082 KIT(s)/Unit Total : 0.164 KIT(s)
Polybond B46F N° de Lot: 1-5865-1

21.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.5000Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 7/03/07

Heure Début:

Heure Fin:

Sceau:



22.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41109

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond.

Date: 7/03/07

Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: _____ Curing Fin: _____

23.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0800 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

24.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

25.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 8/03/07

Heure Début: _____ Heure Fin: _____ Sceau: _____



26.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 1.0000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte .

Faire le laminage du dernier pli de 9.7 oz.















Date: 8/03/07

Heure Début: _____ Heure Fin: _____ Sceau: _____



ate: Mardi, 2007-03-06 09:14:14
utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 41109		Numéro Article: DKC134-0052	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE Faire la poche à vide en appliquant les composantes dans l'ordre suivant: 1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage 4- Sac à vide Stretchlon 200 Laisser sécher pendant 4 heures minimum. Date: <u>8/03/07</u> Heure Début: _____ Heure Fin: _____ Sceau:    Curing Début: _____ Curing Fin: _____			
28.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs DÉMOULAGE DES PIÈCES Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ". Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci Date: <u>9/03/07</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 1.0000Hrs TRIMAGE DE FINITION Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet. Date: <u>9/03/07</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
30.0	AAC0671	Dupont Primer N° 1104S	
Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.2780 GALLON(s) Dupont Primer N° 1104S			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41109

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.5600 PINTE(s)
Dupont Activator N° 7975S

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0700 GALLON(s)
Dupont Reducer N° 12375S

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

MAR 09 2007



Nettoyage qty 1 09-03-07



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

34.0 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer la première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer.

Laisser sécher pendant 3 heures.

MAR 09 2007

Date: Heure Début: Heure Fin: Sceau: 

35.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et enlever le lustre du primer.

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

Date: Mardi, 2007-03-06 09:14:15

Illigateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41109Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

37.0 AAC0646 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.050 KIT(s)/Unit Total: 0.100 KIT(s)
MASTIC POLYSTOP SIKKENS 3AR591

38.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total: 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens N° de Lot: 1-6005-1

39.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.3333Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 12-03-07 Heure Début: / Heure Fin: / Sceau:

40.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.2780 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5931-2

41.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.5600 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-5931-1

42.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0700 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5992-2

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.5000Hrs
PRÉPARATION DU MATÉRIEL

Nettoyages sty 113-03-07

MAR 13 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

44.0 PEINT/PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.6667Hrs
APPLICATION DE PRIMERAppliquer la deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. #
Application du primer

MAR 13 2007

Date: / Heure Début: / Heure Fin: / Sceau:

ate: Mardi, 2007-03-06 09:14:15

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41109

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

45.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs

INSPECTION PIÈCE DART



14/3/07

Emballage 27


14/3/07



Date: Vendredi, 2007-02-09 09:14:40
 Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD BODY
Numéro Job :	40967	Numéro Article :	DKC134-0053
Numéro Soumission :	2585	Numéro Dessin :	D3188
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-02-09 No. B.V. :	Révision dessin :	B C
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Rem. fois :	- - Type :	Date Due :	2007-02-16
Job précédente :	40966	Qté :	1 Udm: UNITE

Ecrit par : 
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Dart Aerospace : D31881M
 N° de Projet Delastek: DK-362

 Process Sheet Rev.: 00 Création du premier à partir du
 DKC134-0019

Produit additionnel






Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006. 5-02-07 Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: <i>DR HG</i>		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s) Stretchlon 200 poche à vide Vert		

ate: Vendredi, 2007-02-09 09:14:41
utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40967		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
7.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentaire Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s) 9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: <u>1-5905-1</u>			
8.0	AC0098	Ruban à gommer jaune #: T/AT-200Y	
Commentaire Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s) Ruban à gommer jaune #: T/AT-200Y			
9.0	AAC0443	Fiberglass 12 oz Unidirectional	
Commentaire Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s) Fiberglass 12 oz Unidirectional N° de Lot: <u>1-5455-1</u>			
10.0	AAC0633	WR1850 ROVING 18 OZ x 50"	
Commentaire Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s) WR1850 ROVING 18 OZ x 50" N° de Lot: <u>1-5873-1</u>			
11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs TAILLAGE DU MATÉRIEL Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci. À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres. <u>5-02-07</u> Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: <u>MG</u>			
12.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
13.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5966-1</u> & <u>1-5957-2</u>			
14.0	AAC0673	Fibre de verre Miapoxy 66	
Commentaire Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: <u>1-5502-1</u>			
15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL Faire la préparation de la résine selon les quantités requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.			

Date: Vendredi, 2007-02-09 09:14:41

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.	Nom Dessin: SPACEPOD BODY
Numéro Job: 40967	Numéro Article: DKC134-0053

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxly 66.

Date: 6-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 6-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SV CG MG

17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

Date: 6-02-07 Heure Début: _____ Heure fin: _____ Sceau: DR SV CG MG

Curing Début: _____ Curing Fin: _____

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)








ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 1-5836-1

Date: Vendredi, 2007-02-09 09:14:41








Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40967		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs TAILLAGE DU MATÉRIEL Tailler et le Foam Core 1" selon plan de découpe et gabarits Date: <u>7-02-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>DR SV</u>			
20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5957-2</u>			
21.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
22.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core. <u>7-02-07 DR</u>			
23.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s) Polybond B46F N° de Lot: <u>1-5865-1</u>			
24.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART À l'aide de polybond, coller ensemble les deux surfaces scellées Disposer des poids sur les pièces pour conserver une pression de collage. Laisser sécher 2 heures minimum. Quantité: <u>1</u> Date: <u>7-02-07</u> Sceau: <u>DR SV</u>			








ate: Vendredi, 2007-02-09 09:14:41
utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40967		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Quantité: _____ Date: _____ Sceau: _____			
25.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART			
Ajuster chacune des pièces de foam core dans le moule selon le dessin.			
Quantité: <u>1</u> Date: <u>7-02-07</u> Sceau: <u>DR SV</u>			
Quantité: _____ Date: _____ Sceau: _____			
26.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.			
N° de Lot: <u>1-5957-2</u>			
27.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s) Catalyst N° DDM-9			
N° de Lot: <u>5921</u>			
28.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs PRÉPARATION DU MATÉRIEL DART			
Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes.. <u>7-02-07 SV</u>			
29.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs FABRICATION GÉNÉRALE DART			
Retirer les pièces de foam core du moule			
Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G. # Sceller le Foam Core			
Laisser sécher pendant 2 heures minimum.			
Date: <u>7-02-07</u> Sceau: _____ Initiales: <u>DR SV</u>			








ate: Vendredi, 2007-02-09 09:14:41
Utilisateur: Marc Dubé

Feuille de Procédé








Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40967		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
30.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s) Polybond B46F N° de Lot: <u>1-5865-1</u>			
31.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL Faire la préparation du Polybond. <u>7-02-07</u> Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: <u>DR SU CG HLG</u>			
32.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond. <u>7-02-07</u> Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: <u>DR SU CG HLG</u>			
33.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE Faire la poche à vide en appliquant les composantes dans l'ordre suivant: 1- Tissu à délaminer, 2- Feutre de drainage 3- Sac à vide Stretchlon 200 Laisser sécher pendant 2 heures minimum. Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé <u>7-02-07</u> Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: <u>DR SU CG HLG</u> Curing Début: _____ Curing Fin: _____			

ate: Vendredi, 2007-02-09 09:14:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40967		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
34.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens	
Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens N° de Lot: <u>1-5957-1</u>			
35.0	AC0059	Durcisseur Polysoft #004009 Sikkens	
Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s) Durcisseur Polysoft #004009 Sikkens			
36.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs FINITION GÉNÉRALE Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts, utiliser du polybond. Date: <u>8-02-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>DR CG</u>			
37.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART <u>8-02-07 DR</u> Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.			
38.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5957-1</u>			
39.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
40.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le form Core Laisser sécher pendant 2 heures minimum.			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40967		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Quantité: _____ Date: _____ Sceau: _____			
Quantité: <u>1</u> Date: <u>8-02-07</u> Sceau: <u>DR SV</u>			
41.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5966-1</u>			
43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>8-02-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>CG</u>			
44.0	LAMINAGE	LAMINAGE PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs FAIRE LE LAMINAGE DES TISSUS Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule. Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9. Date: <u>8-02-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>DR SV CG MG</u>			
45.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE Faire la poche à vide en appliquant les composantes dans l'ordre suivant: 1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage			

Date: Vendredi, 2007-02-09 09:14:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40967

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 8-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SU CG HG

Curing Début: _____ Curing Fin: _____

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 9-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Perçer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.

Par l'intérieur, perçer les 8 dégagement de ø .745" pour les spacers. (Ne pas perçer la peau extérieur de la pièce)

Date: 9-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

48.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5957-2

Date: Vendredi, 2007-02-09 09:14:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40967

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

50.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5958-1

51.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 9-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

52.0 AAC0448 Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)
Spacer N° D2213 N° de Lot: 1-5949-1

53.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre Miapoxy 66

Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous.

Appliquer une pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes.

Laisser sécher pendant 4 heures minimum.

Date: 9-02-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

Curing Début: _____ Curing Fin: _____













54.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

Date: Vendredi, 2007-02-09 09:14:41
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 40967		Numéro Article: DKC134-0053	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
55.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.			
N° de Lot: <u>1-5988-1</u>			
56.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.			
Date: <u>12/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
57.0	LAMINAGE.	LAMINAGE PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs FAIRE LE LAMINAGE DES TISSUS			
Retirer les pinces et les blocs de bois			
Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièce selon le dessin.			
Laisser sécher pendant 4 heures minimum.			
Date: <u>12/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau:   FORMATION 			
Curing Début: _____ Curing Fin: _____			
58.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART			
Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.			
Percer les 8 trous des spacers afin de les déboucher.			
Quantité: <u>1</u> Date: <u>15-02-07</u> Sceau: 			
Quantité: _____ Date: _____ Sceau: _____			

Date: Vendredi, 2007-02-09 09:14:41

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40967

Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

59.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S

60.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activator N° 7975S

61.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

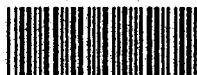
Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

FEB 15 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

63.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

FEB 15 2007

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____



64.0 AAC0445 Label N° D0600-141

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Label N° D0600-141 N° de Lot: _____

65.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total : 0.015 GALLON(s)
Résine Mia-Poxy N° de Lot: _____

66.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTE(s)/Unit Total : 0.030 PINTE(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: _____

67.0 AAC0444 Surface Veil

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Surface Veil N° de Lot: _____

Date: Vendredi, 2007-02-09 09:14:41

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40967

Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

68.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DART

N/A

Coller le label D0600-141 sur le spacepod en plaçant un suface veil eu dessous et par dessus le label à l'aide de résine Mia Poxxy selon I.F. # DKC134-0019-13

Date: _____ Heure débur: _____ Heure fin: _____ Sceau: _____

69.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-5975-1

70.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

71.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs

FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage (grit 220) de toutes les surfaces.

Date: 6-02-07 Heure Début: / Heure Fin: / Sceau: 61

72.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.2500 GALLON(s)/Unit Total: 0.2500 GALLON(s)

Dupont Primer N° 1104S N° de Lot: 1-5931-2

73.0 AAC0670 Dupont Activator N° 7975S

Commentaire Qty.: 0.5000 PINTE(s)/Unit Total: 0.5000 PINTE(s)

Dupont Activator N° 7975S N° de Lot: 1-5931-1

74.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s)

Dupont Reducer N° 12375S N° de Lot: 1-5931-3

75.0 PREPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

PRÉPARATION DU MATÉRIEL

Masquer le label.

FEB 16 2007



Feuille de Procédé

Client: DART Dart Aerospace Ltd. Nom Dessin: SPACEPOD BODY
Numéro Job: 40967 Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

76.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

FEB 16 2007

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____



77.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION GÉNÉRALE

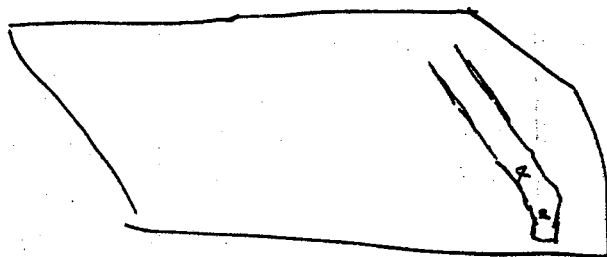
Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 16-2-07 Sceau: _____



Initiales: _____

Emballage QT 1 19/2/07



FOAM CORE UN PEU ÉCRASE
N'A PAS D'IMPACT AU NIVEAU
STRUCTURAL SELON FB INC

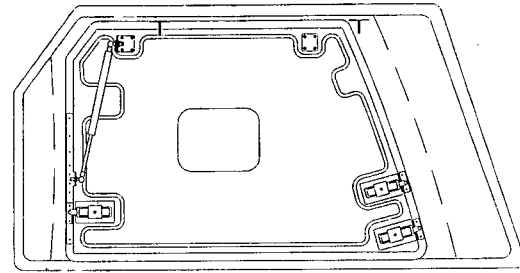
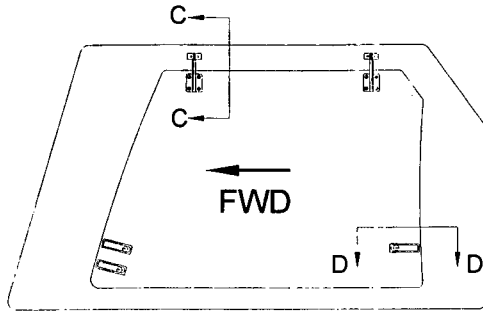


FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)

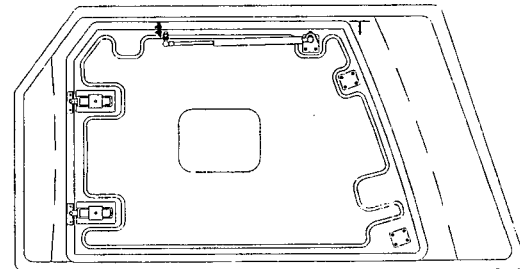
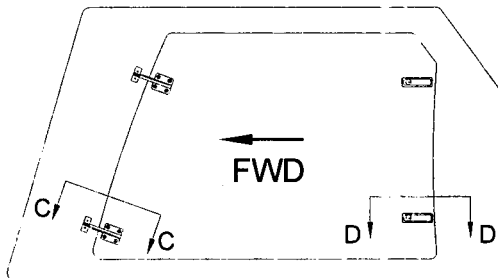
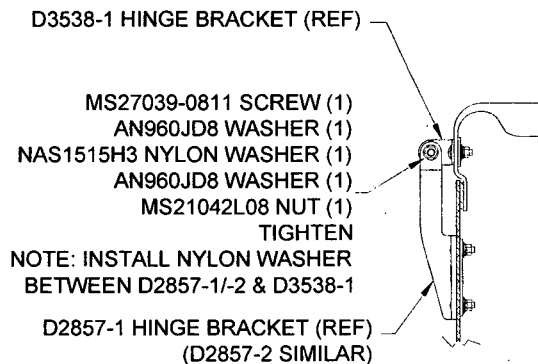
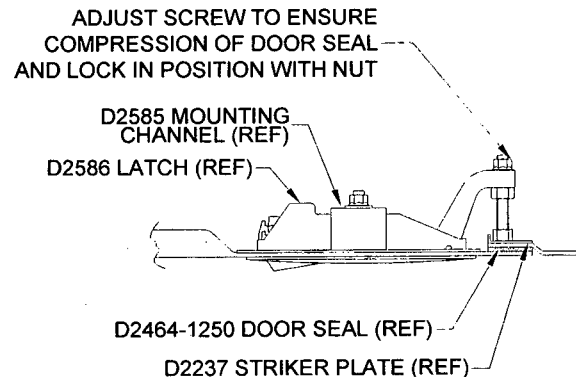


FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



SECTION 'C-C' HINGE
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



SECTION 'D-D' LATCH

- 3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:
- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
 - If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
 - Re-install the belly panel per the Aircraft Maintenance Manual.

- 3.2.13 Relocate the forward door-open switch using the D350-600-349/-449 Door Switch Relocation Kit in accordance with Section 3.6 of this IIN.
- 3.2.14 Re-install the cargo restraining system per Section 4.0 of this IIN.
- 3.2.15 Complete any other maintenance required prior to returning to service.
- 3.2.16 Install the D2985 decal on a clearly visible area of the instrument panel.

3.3 **AUTOMATIC DOOR OPENER SPACEPOD™ UPGRADE KIT INSTALLATION (D350-600-149)**

- 3.3.1 Remove the following components from the existing **Spacepod™** as shown in Figure 7:
 - a. Remove the **Spacepod™** door by disconnecting the hinges. Retain the door for reinstallation.
 - b. Remove and discard the D2982-041 prop arm assembly, the D2429-041 spring clip assembly and the D2012-107 clevis.
 - c. Remove and discard the D2219 door support bracket with the ball stud and hardware by drilling out the rivet holes to Ø0.129" (drill #30).
 - d. Remove the aft D2237 striker plate by drilling out the rivet holes to Ø0.129" (drill #30) and retain for reinstallation.

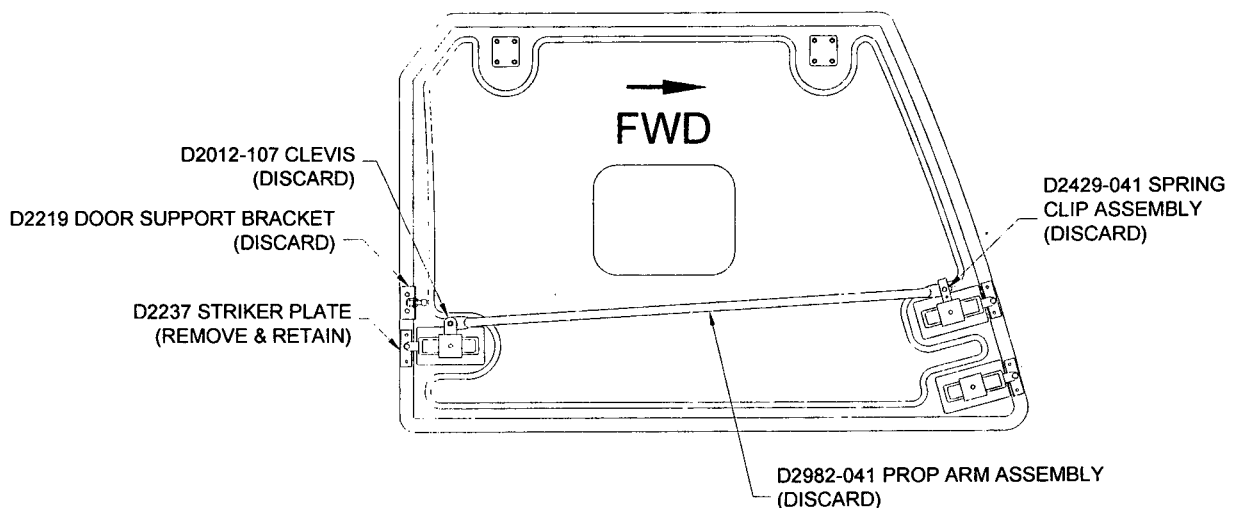
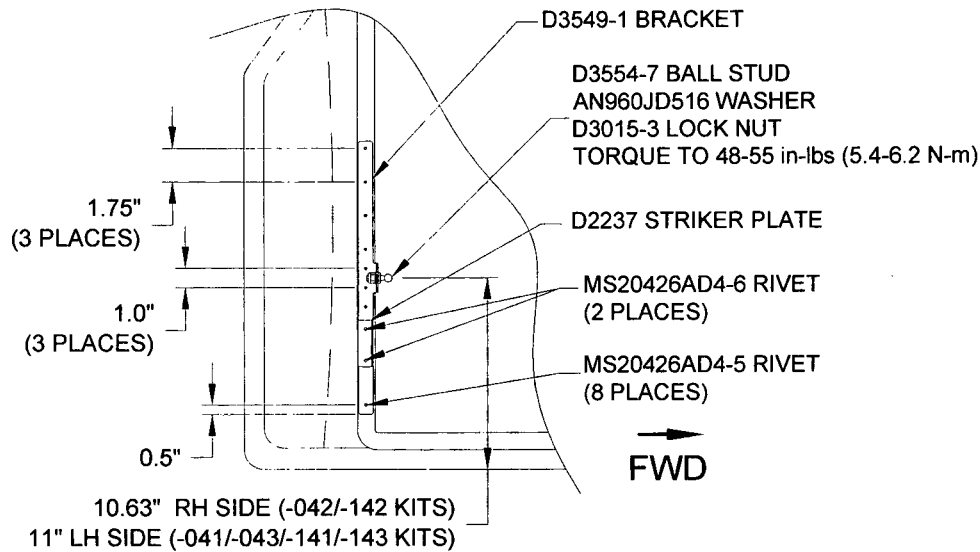


FIGURE 7. COMPONENT REMOVAL FROM EXISTING SPACEPOD DOOR
(INSIDE VIEW SHOWN; -041/-141 KIT SHOWN; -042/-142 OPPOSITE, -043/-143 SIMILAR)

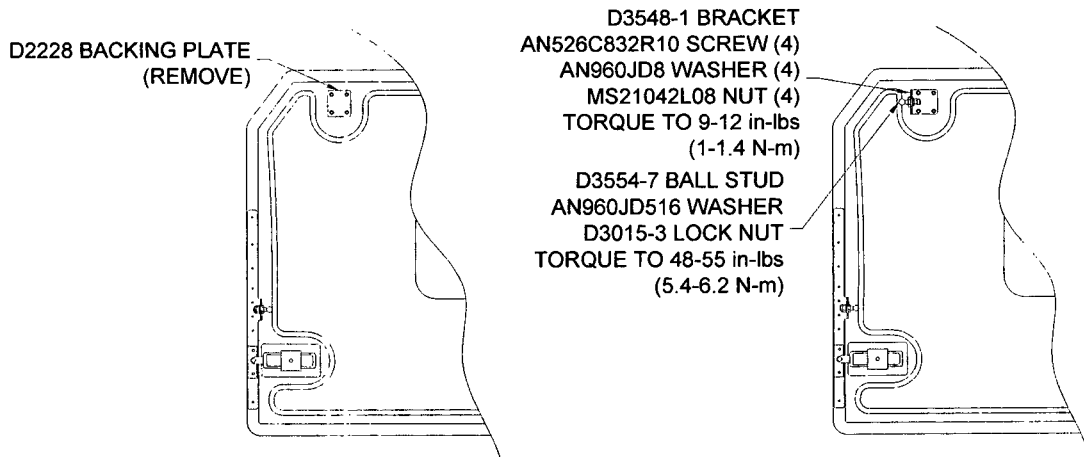
- 3.3.2 Install the D3549-1 bracket as shown in Figure 8:
 - a. Position the D3549-1 bracket as shown.
 - b. Transfer drill from the existing Ø0.129" holes in the pod that were used to install the D2237 striker plate and D2219 door support bracket (removed in Step 3.3.1) to the D3549-1 bracket.
 - c. Locate and drill 2 more Ø0.129" holes through both the pod and the D3549-1 bracket that are 1" above and below the original D2219 door support bracket holes.
 - d. Locate and drill 3 more Ø0.129" holes through the pod and the upper portion of the D3549-1 bracket on a 1.75" pitch as shown.

- e. Locate and drill 1 more Ø0.129" hole 0.5" from the base of the D3549-1 bracket through the bracket and the pod.
- f. Install the D3549-1 bracket and D2237 striker plate using rivets as shown.
- g. Install the D3554-7 ball stud as shown.

**FIGURE 8. BRACKET INSTALLATION**

(INSIDE VIEW SHOWN; -041/-141 KIT SHOWN; -042/-142 OPPOSITE, -043/-143 SIMILAR)

- 3.3.3 Replace the D2228 backing plate with the D3548-1 bracket on the aft D2857-1/-2 hinge bracket using new fasteners as shown in Figure 9. Install the D3554-7 ball stud as shown.

**FIGURE 9(a). HINGE PLATE REMOVAL****FIGURE 9(b). BRACKET INSTALLATION****FIGURE 9. BRACKET INSTALLATION**

(INSIDE VIEW SHOWN; -041/-043/-141/-143 SPACEPOD SHOWN; -042/-142 OPPOSITE)

- 3.3.4 Remove the D2977 and D2978 hinge brackets from the pod. Assemble the D3538-3 hinge brackets on the door with the D2857-1/-2 hinge brackets as shown in Figure 10. Position the door on the *Spacepod™* and transfer mark the mounting holes from the pod to the hinge brackets. Ensure that there is a minimum of 0.24" from each mark to the edges of the D3538-3 bracket. Drill the marked holes on the hinge brackets to $\varnothing 0.172$ ". Install the hinge brackets and door as shown.

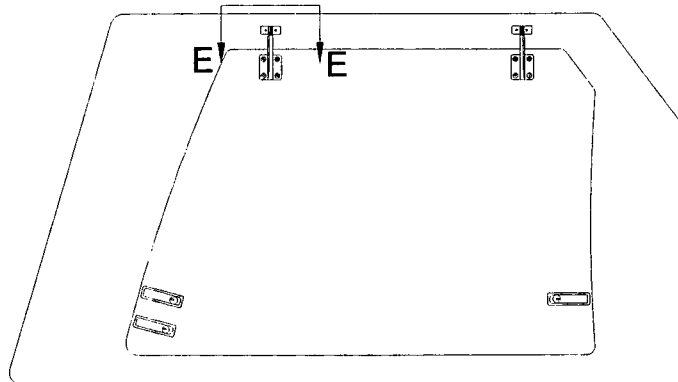
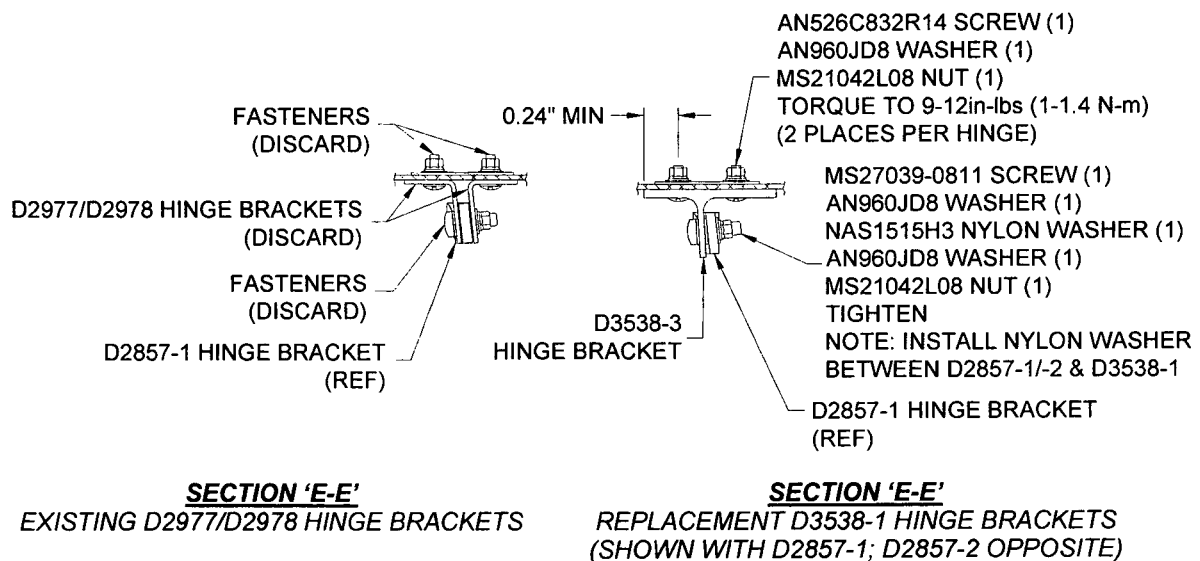


FIGURE 10. HINGE BRACKET REPLACEMENT
(OUTSIDE VIEW SHOWN; -041/-141 SHOWN; -043/-143 SIMILAR, -042/-142 OPPOSITE)



- 3.3.5 Install the D3552-9 gas spring rod end down on the ball studs.

- 3.3.6 Adjust the latches as necessary to ensure that the door closes tightly and securely.

3.4 FORWARD OPENING SPACEPOD™ UPGRADE KIT INSTALLATION (D350-600-249)

- 3.4.1 Remove the existing D3186-1/-2 *Spacepod™* door by disconnecting the hinges.
- 3.4.2 Remove the following components from the door and pod as shown in Figure 11:
- Remove the D2977/D2978 hinge brackets and D2179 hinge bracket plates from the pod. Reinstall the hardware to fill the holes in the pod. Retain the hinge bracket plates for reinstallation. Discard the hinge brackets.
 - Remove the D2857-1/-2 hinge brackets and the D2228 backing plates and retain for reinstallation. Reinstall the mounting hardware in the aft set of holes only. Discard the remaining mounting hardware.
 - Remove the two forward D2586 latches, D2621 latch plates and D2588 mounting channels along with the D2982-041 prop arm assembly, the D2012-107 clevis assembly and D2429-041 spring clip assembly. Retain one D2586 latch, one D2621 latch plate and one D2588 mounting channel for reinstallation. Discard the other parts and hardware.
 - Remove the SL69-BS ball stud and discard.
 - Optional – remove the D2219 door support bracket by drilling out the rivets. Fill in the pod rivet holes in pod using new rivets.

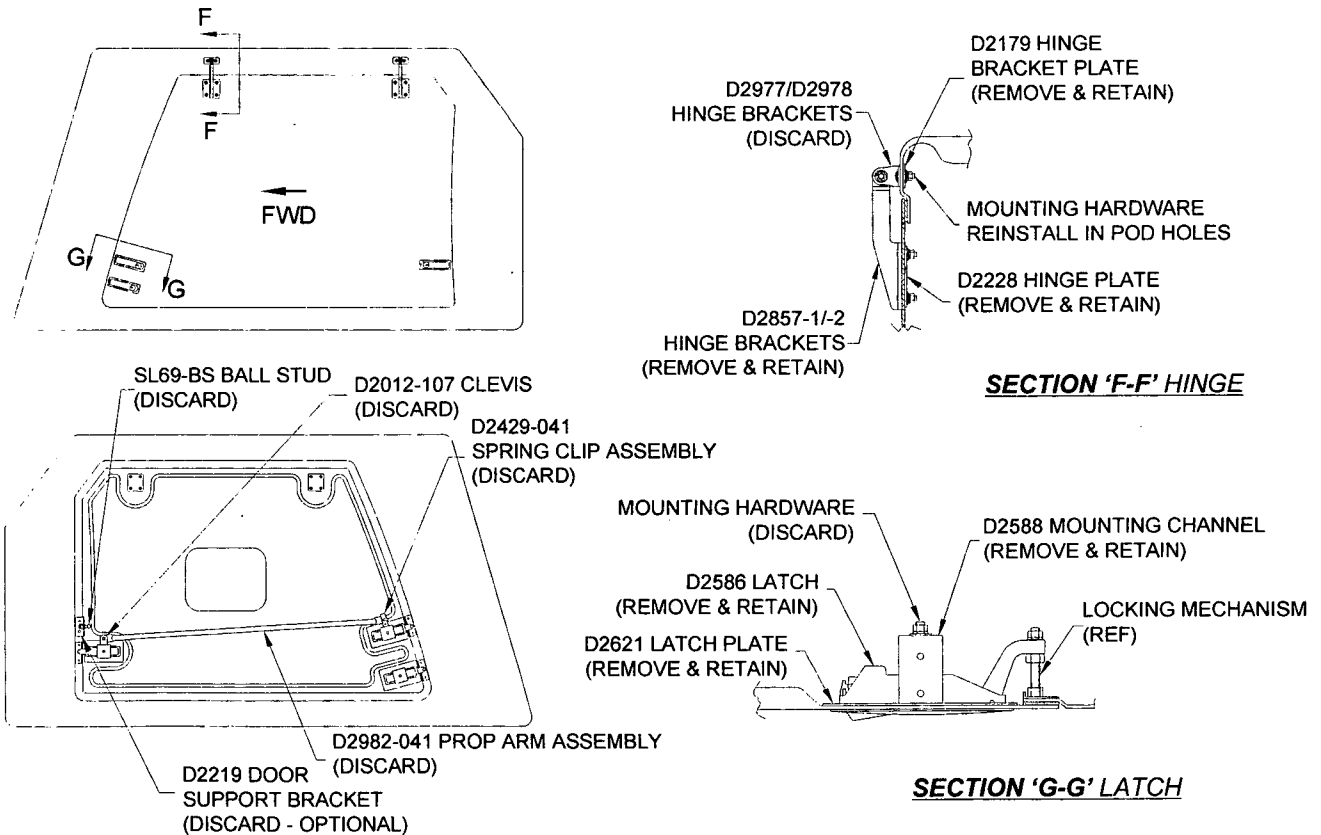


FIGURE 11. COMPONENT REMOVAL FROM EXISTING SPACEPOD KIT
(D350-600-041/-141 KIT SHOWN; -042/-142 OPPOSITE, -043/-143 SIMILAR)

- 3.4.3 Fill each of the two forward latch holes as shown in Figure 12. (Note that it is optional to fill in only the lower latch hole and to leave the latch in the upper latch hole. If this option is chosen, remove the locking mechanism from the latch. Refer to Figure 11).
- Prepare a pre-cured fiberglass plug to fit the hole using alternating 45° layers of cloth. Ensure that the plug has the same thickness and size of the opening.
 - Prepare two plies of 9 oz 7781 glass cloth that will overlap the hole by 0.5". Prepare two plies of 9 oz 7781 glass cloth that will overlap the hole by 1" and that are oriented 45° from the first set of plies. Prepare two plies of 9 oz 7781 glass cloth that will overlap the hole by 1.5" and that are oriented in the same direction as the first set of plies.
 - Prepare the door surface by sanding a minimum of 1.5" from each edge of the hole on both sides of the door to a minimum of 80-grit. Remove the D2464-1250 neoprene seal around the area as needed. Remove dust and grease using a mild solvent. Wipe the solvent before drying. Ensure that all paint, primer and grease are removed.
 - Bond the plug in the opening with Hysol EA9309NA adhesive paste or equivalent.
 - Layer 3 plies of glass cloth on each side of the hole from smallest to largest with Epocast 50-A/9816 or Hysol EA9309NA resin.
 - Apply pressure to both sides of the hole and allow the resin to cure.
 - Smooth the applied area and prime and paint.

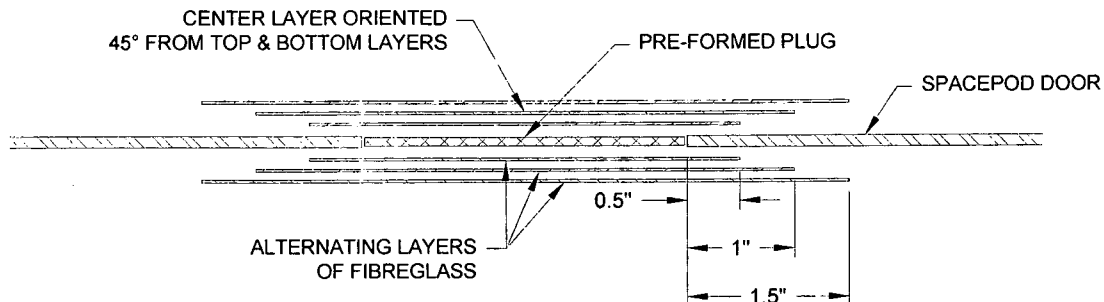


FIGURE 12. LATCH HOLE REPAIR IN SPACEPOD DOOR

- 3.4.4 Prepare the new latch and hinge bracket mounting locations as shown in Figures 13(a) and 13(b):
- Cut away the inner fiberglass layer and the thick foam layer on the *Spacepod™* door as shown. Leave a 45° tapered edge along each area.
 - Prepare two plies of 9 oz 7781 glass cloth that will overlap each exposed area by 1" and by 1.5", respectively. Ensure that the two plies are oriented 45° to each other.
 - Prepare the door surface by sanding a minimum of 1.5" from each edge surrounding the exposed areas on the inner surface of the door to a minimum of 80-grit. Remove the D2464-1250 neoprene seal around the area as needed. Remove dust and grease using acetone or equivalent solvent. Wipe the solvent before drying. Ensure that all paint, primer and grease are removed.
 - Layer the two plies of glass cloth on each exposed area from smallest to largest with Hysol EA9309NA or Epocast 50-A/9816 resin.
 - Apply pressure to the area and allow the resin to cure.
 - Smooth the applied area and prime and paint.

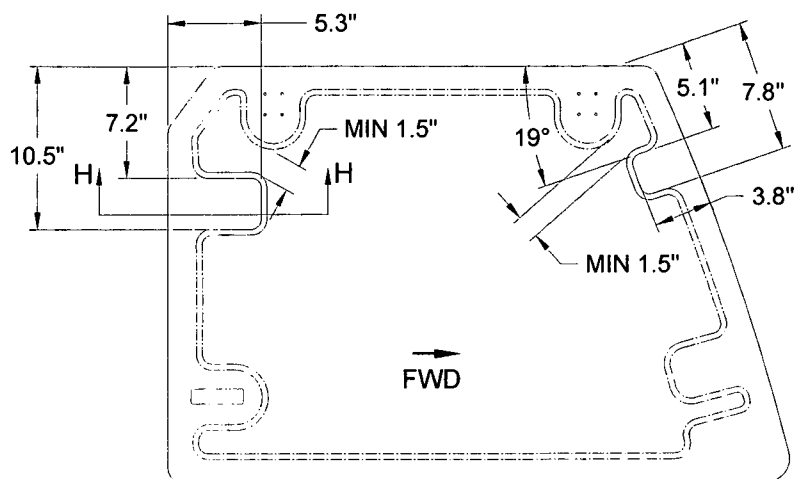


FIGURE 13(a). D3186-1 SPACEPOD DOOR COMPOSITE MODIFICATION
(APPLICABLE FOR -041/-043/-141/-143 KITS)

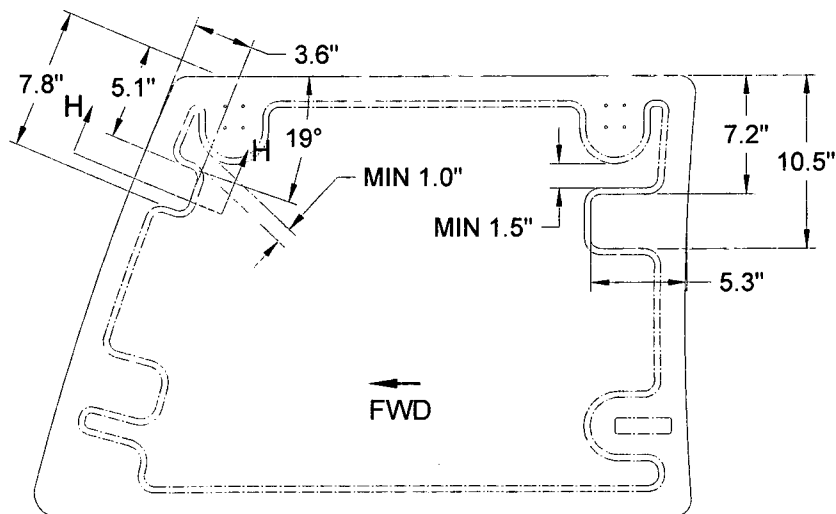
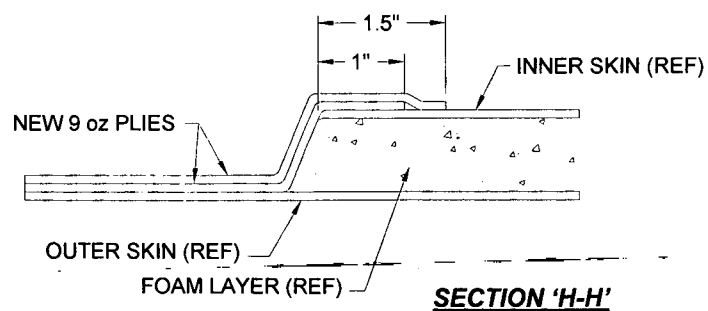


FIGURE 13(b). D3186-2 SPACEPOD DOOR COMPOSITE MODIFICATION
(APPLICABLE FOR -042/-142 KITS)



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Date: 07.02.20

3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.

3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

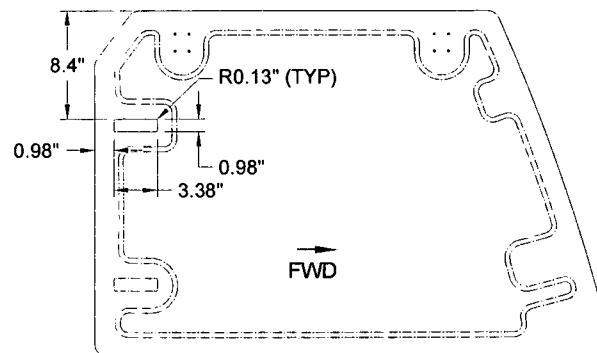


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

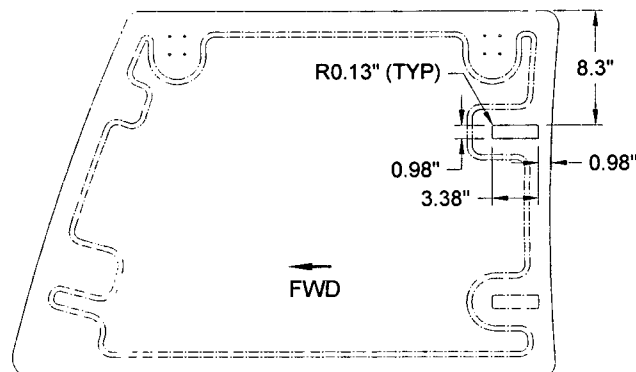


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

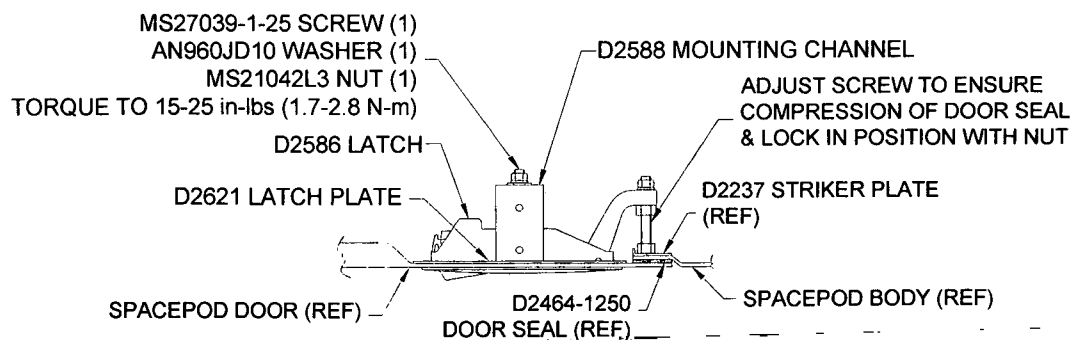


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the Ø0.172" mounting holes on each bracket to the *Spacepod™* door. Install the hinge brackets as shown in Section J-J.

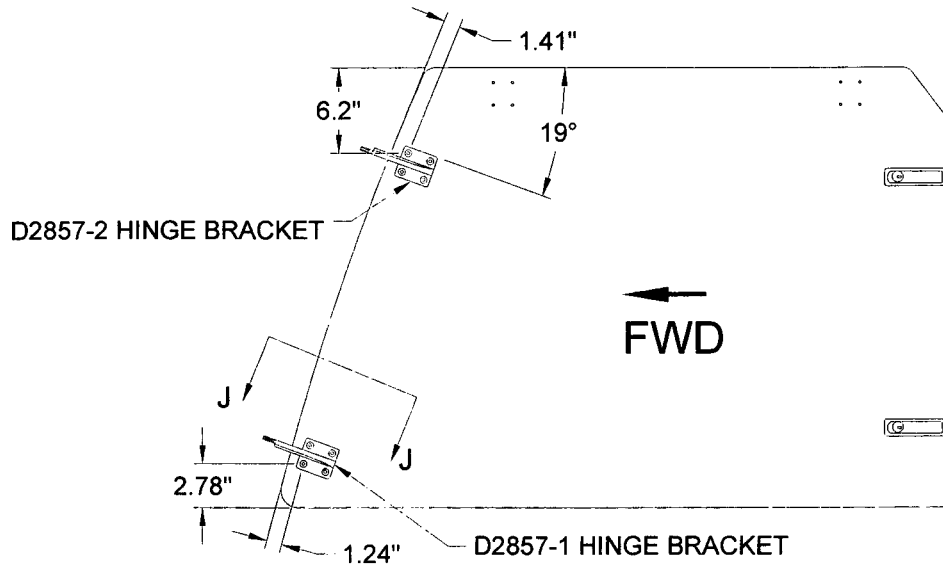


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

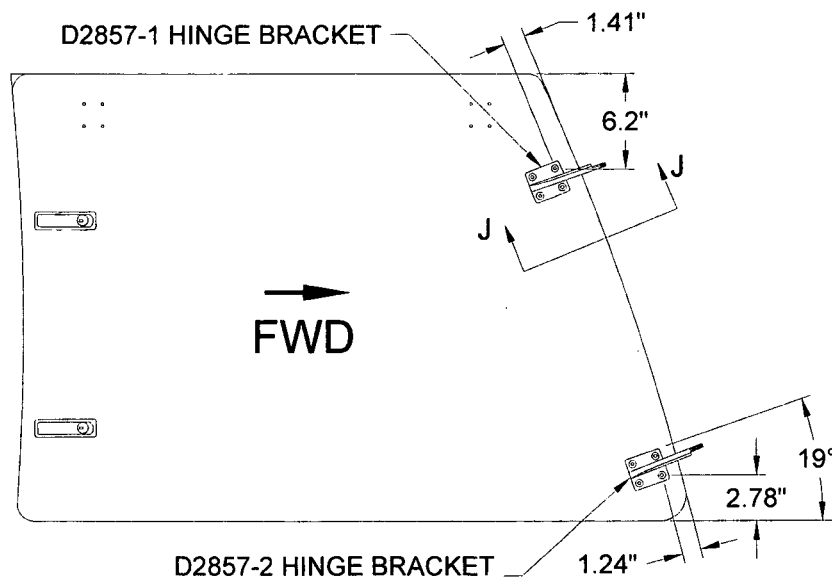
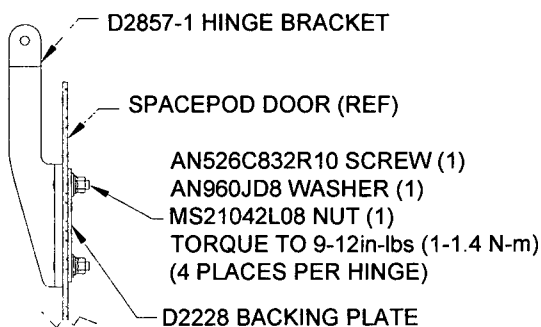


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR



SECTION 'J-J' HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

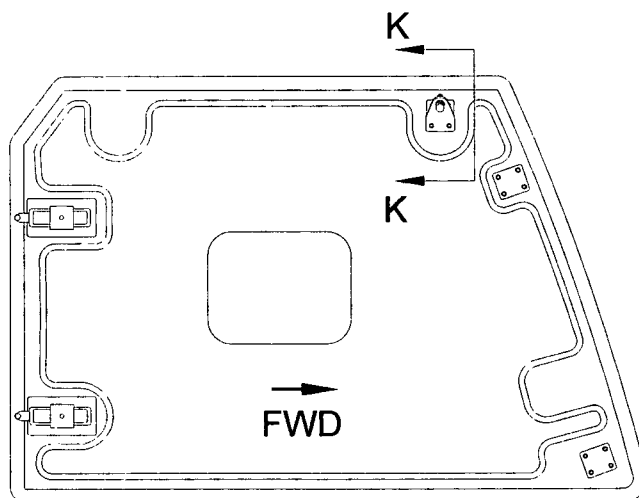
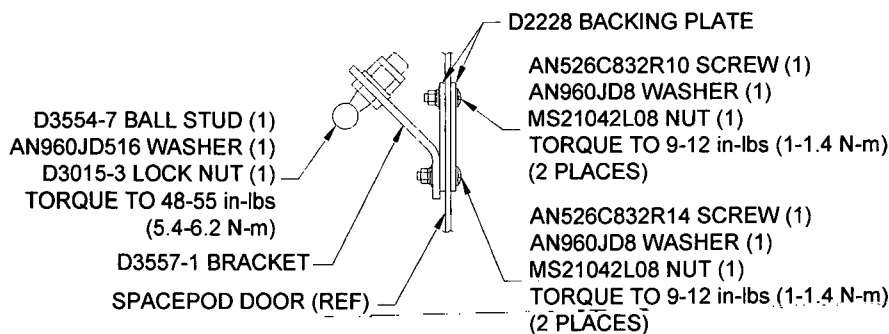


FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



SECTION 'K-K'

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- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

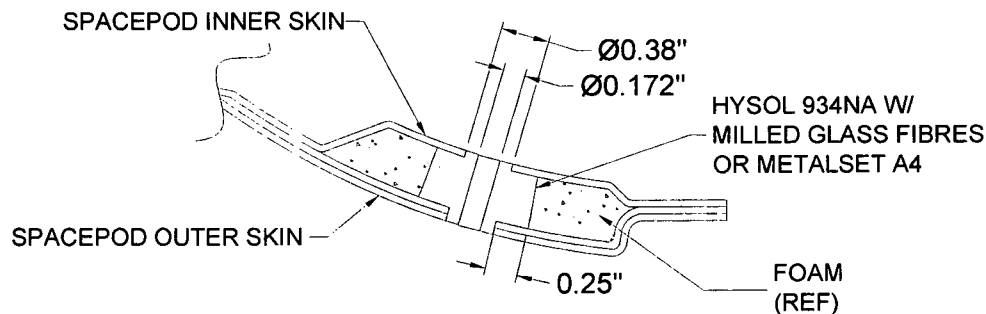


FIGURE 17(a). COMPOSITE MODIFICATION

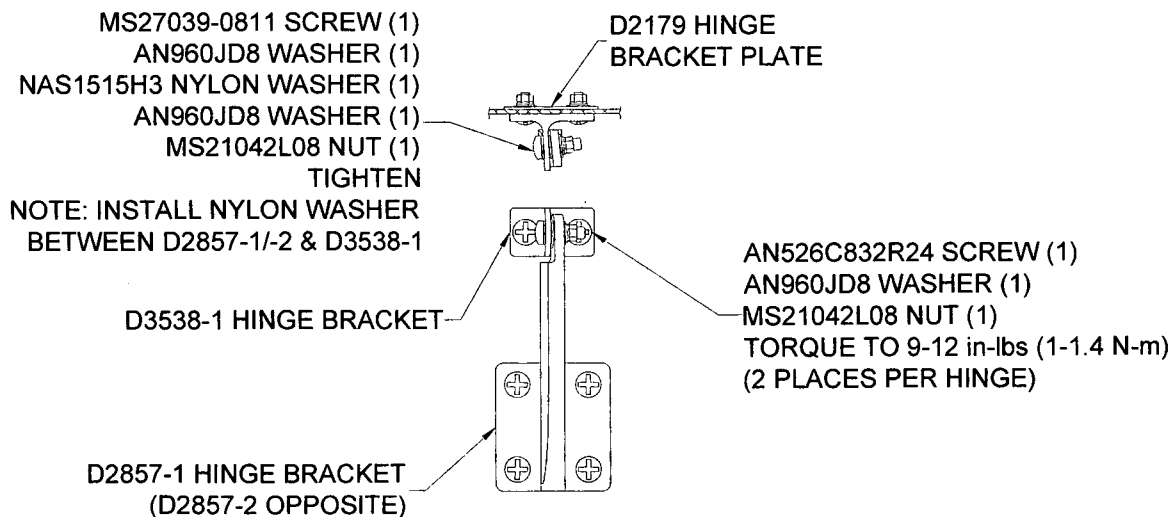


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE).

- 3.4.10 Align the D2237 striker plate with the upper latch. Transfer mark the two holes and drill to $\varnothing 0.129$ " (drill #30). Install the striker plate using two MS20426AD4-5 rivets. Refer to the lower aft striker plate as an example. Refer to Figure 14(c).
- 3.4.11 Install the D3547-1 bracket, D3554-7 ball stud and D3550-1 strut as shown in Figure 18:
- If the four outboard fasteners on the aft D2174-041 web assembly in the **Spacepod™** are rivets, drill out the rivets to $\varnothing 0.172$ ". If the four outboard fasteners on the web assembly are threaded fasteners, remove the fasteners.
 - Install the D3547-1 bracket with the D3554-7 ball stud with new fasteners and torque as shown.
 - Position the D3550-1 strut so that the pre-drilled end aligns with the mounting hole on the D3547-1 bracket and so that the other end aligns with one of the roof mounting holes at the forward web assembly as shown. If necessary, trim the end of the strut to fit. Remove the roof fasteners at this hole. Transfer drill $\varnothing 0.194$ " (drill #10) from the roof to the strut.
 - Install new fasteners to connect the **Spacepod™** roof, web assembly and strut as shown. Torque the fasteners as shown.

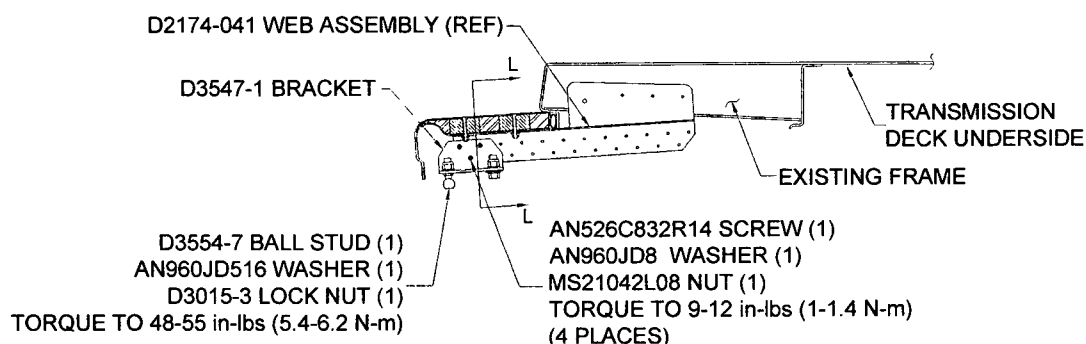
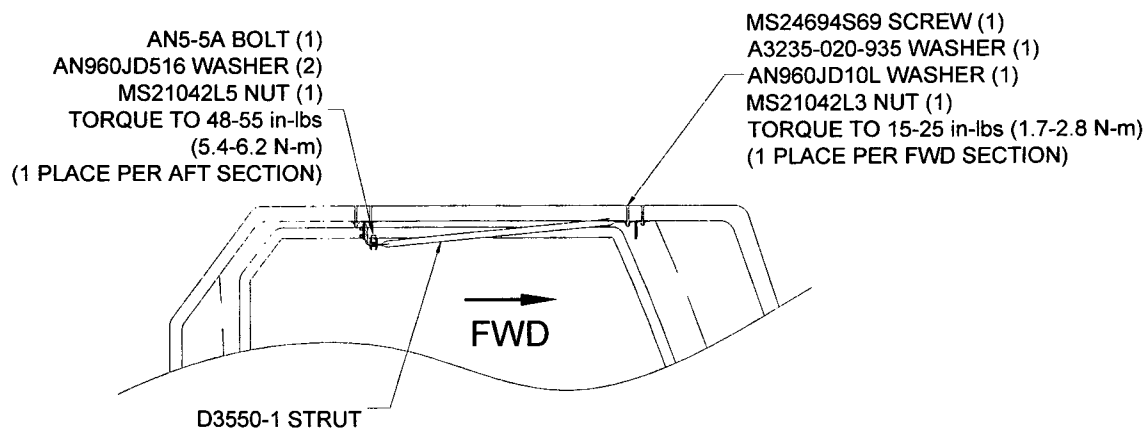


FIGURE 18. BRACKET AND BALL STUD INSTALLATION
(LHS SIDE -041/-141/-043/-143 KITS SHOWN; RH SIDE -042/-142 KITS OPPOSITE)



SECTION 'L-L' STRUT INSTALLATION

- 3.4.12 Install the D3552-7 gas spring rod end down on the ball studs.
- 3.4.13 Adjust the latches as necessary to ensure that the door closes tightly and securely.

Date: Wednesday, 3/7/2007 4:28:25 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 31080C		
Estimate Number	: 12635		
P.O. Number	: N/A	Part Number	: D31863
This Issue	: 3/7/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3186 REV.D
First Issue	: 3/7/2007	Project Number	: N/A
Previous Run	: 31078C	Drawing Revision	: D
		Material	: N/A
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	31080C01	SPACEPOD DOOR LH
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Comment: Sub-Component SPACEPOD DOOR LH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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D3186-1M w/o 30017



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

ml 07/03/28 xl

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/03/28

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

ml 07/03/30

Job Completion



U. 07.03.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (D) Date: 07/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

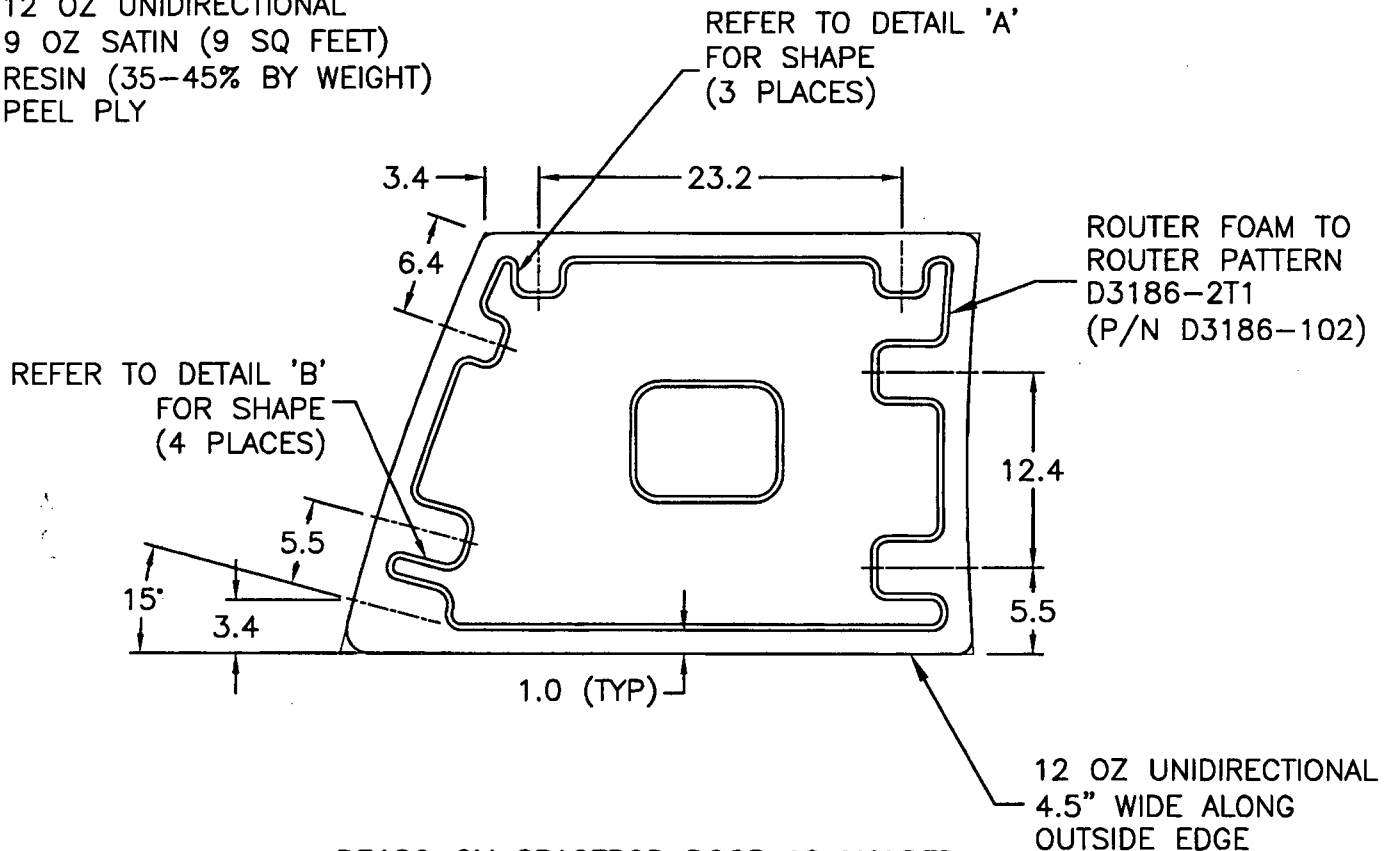
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
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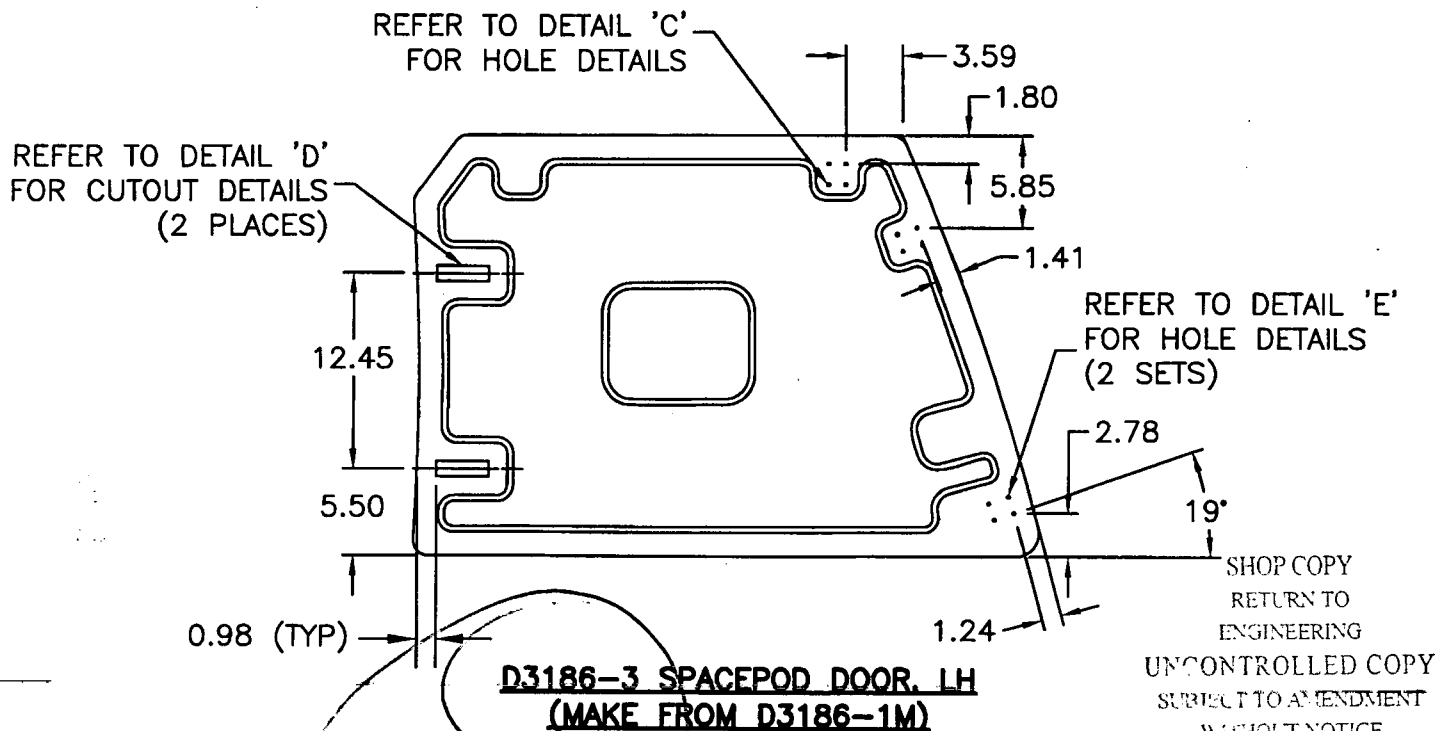
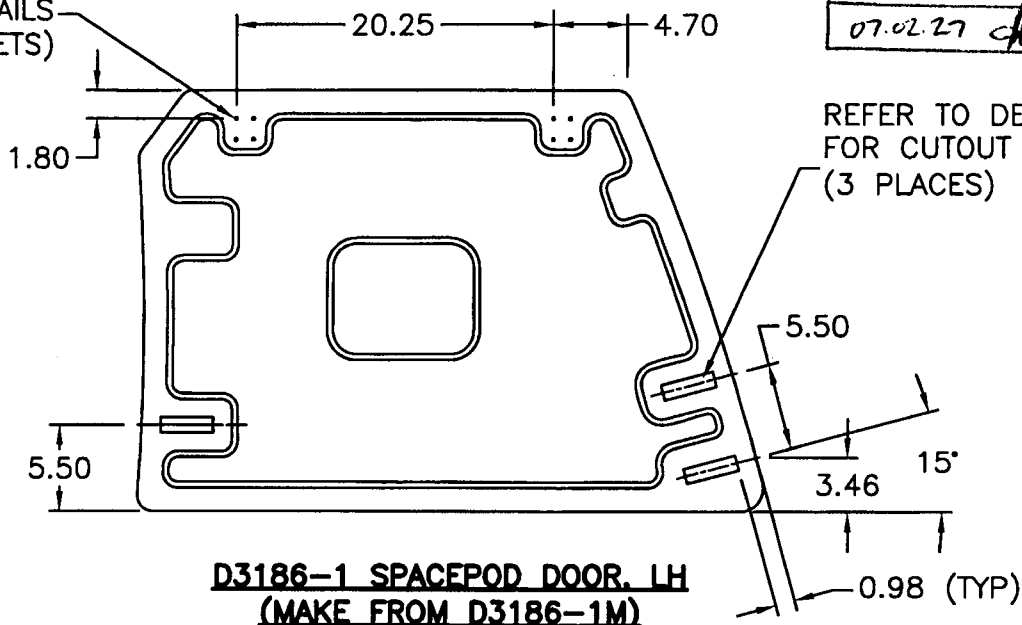
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

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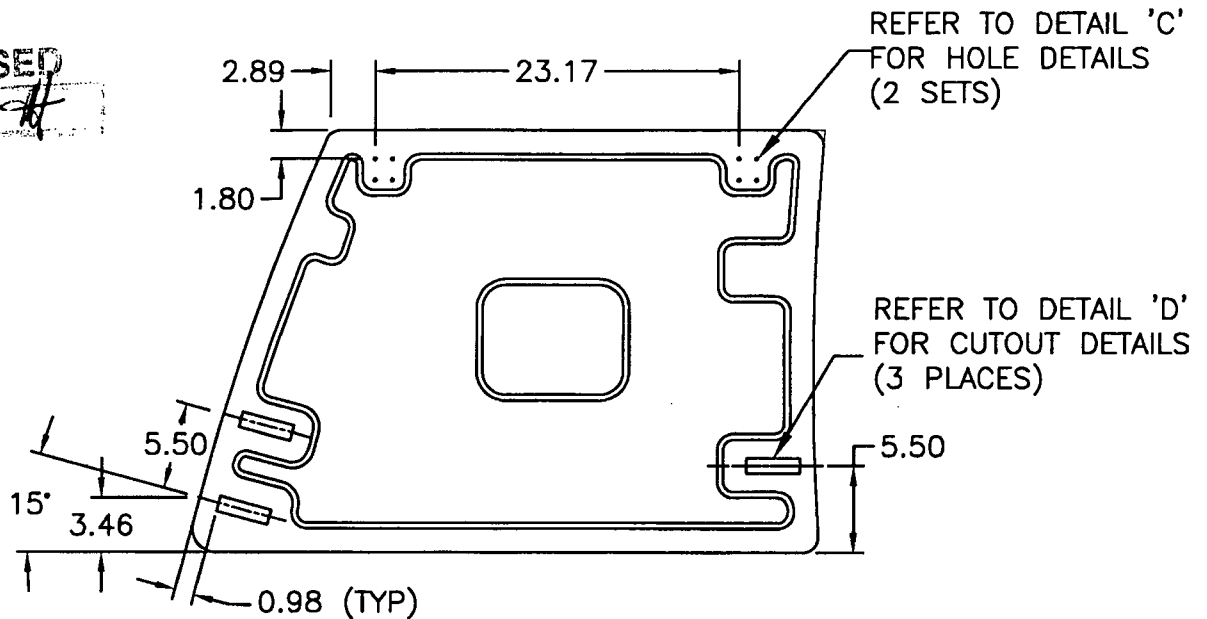
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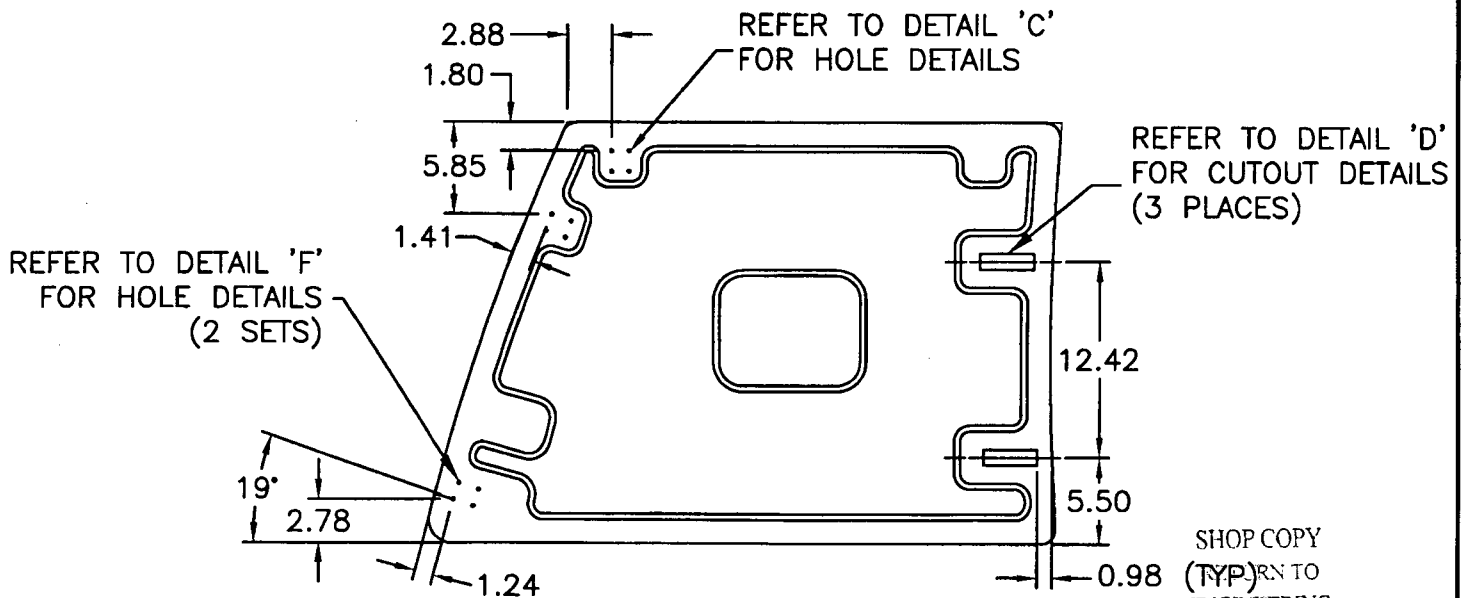
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

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D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

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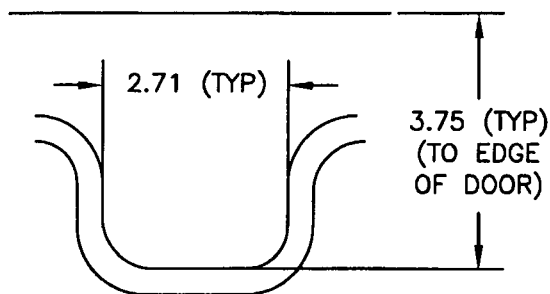
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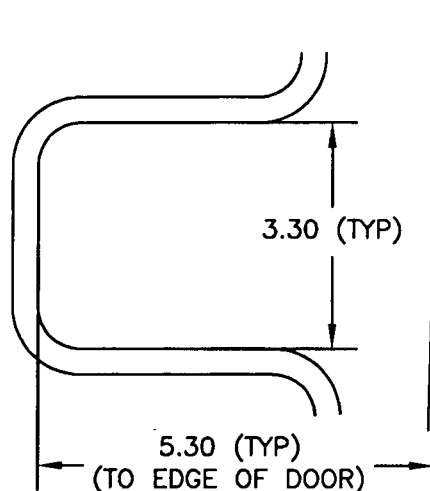
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



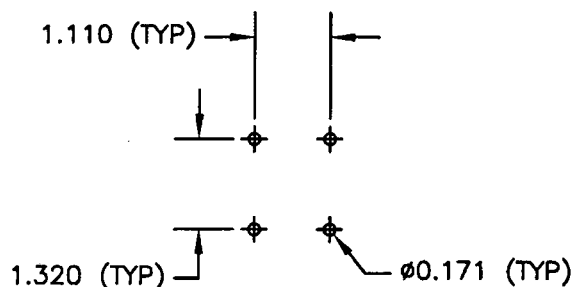
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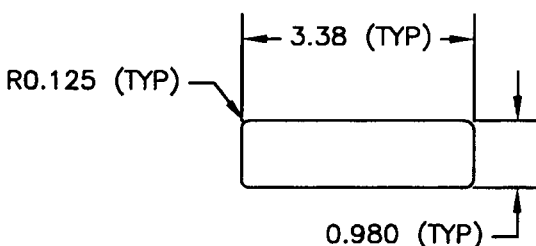
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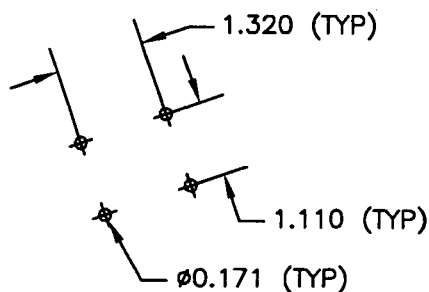


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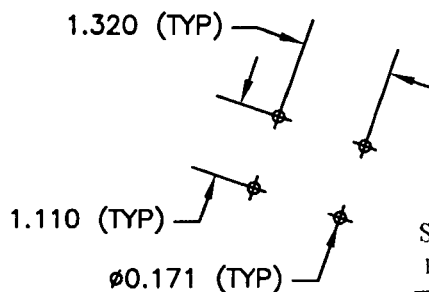


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DETAIL D



DETAIL E



DETAIL F

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Date: Wednesday, 12/20/2006 1:44:41 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 30017		
Estimate Number	: 12598		
P.O. Number	: N/A	Part Number	: D31861M
This Issue	: 12/20/2006 S.O. No. : N/A	Drawing Number	: D3186 REV <i>B/C LE 07.01.18</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: <i>B/C LE 07.01.18</i>
Previous Run	: 30016	Material	:
Written By	:	Due Date	: 2/5/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature] 061220</i>		
Comment	: Est Rev:A New Issue 06-12-04 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2767*

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

CZ 0612121 ①

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins.

ml 07/03/26

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA**ml 07/03/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:44:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 30017

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

207103130

Job Completion



U 57.03.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

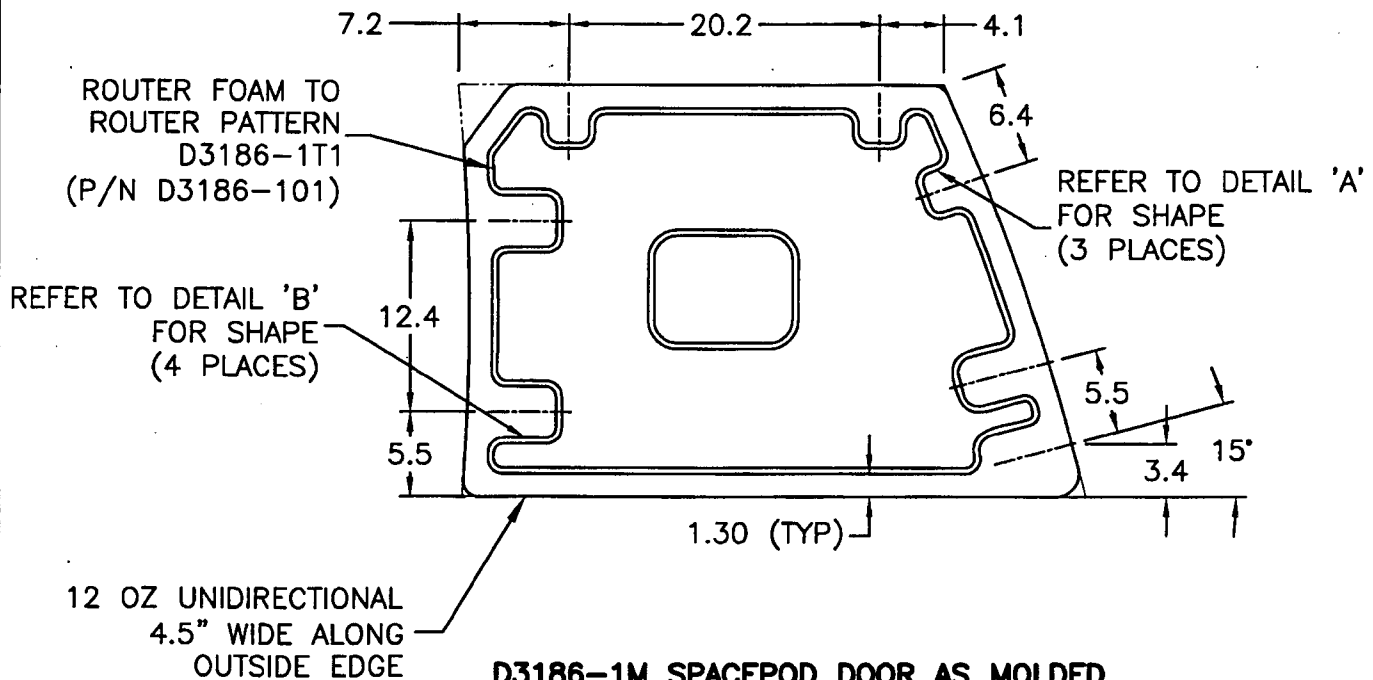
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****RELEASED**
06.12.22 H**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30017

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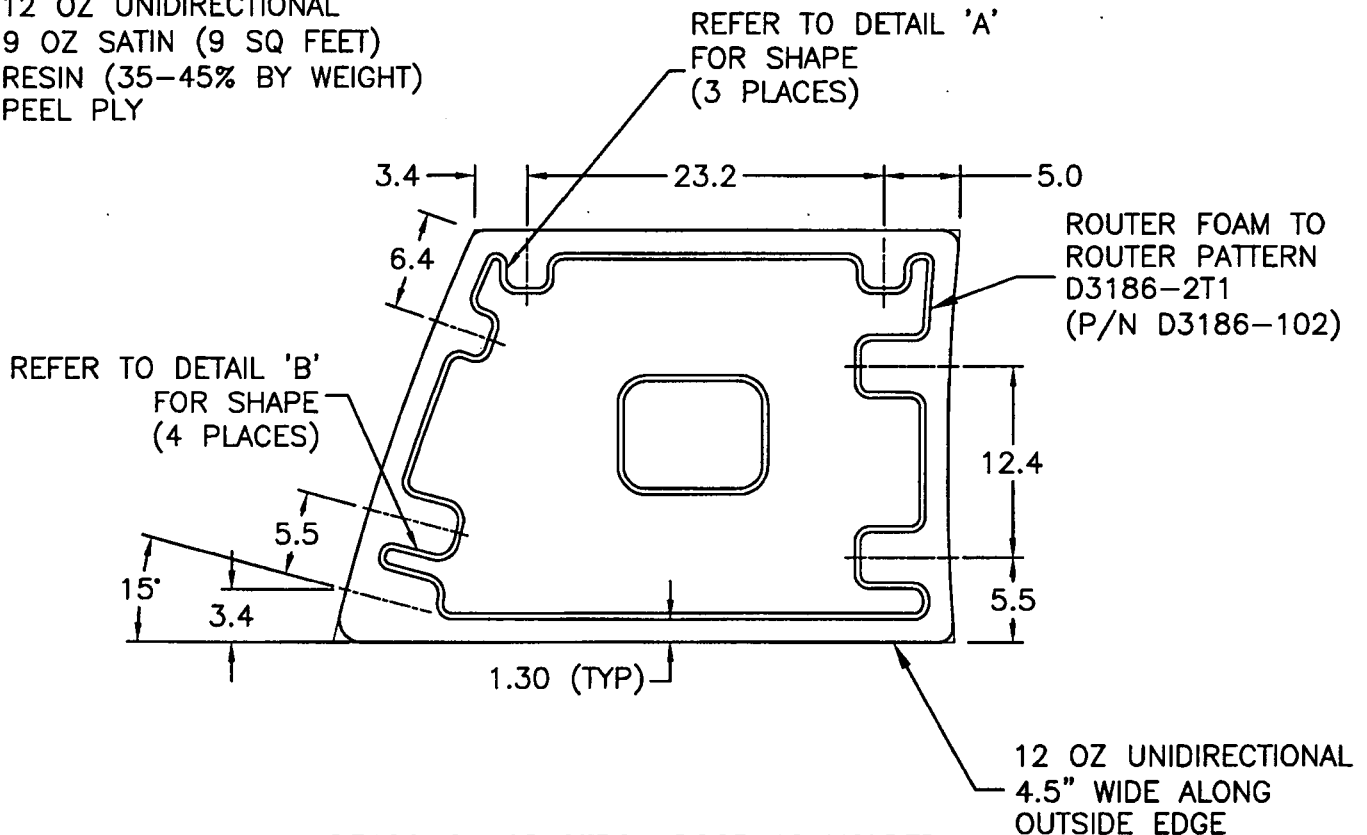
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DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
06.12.13

D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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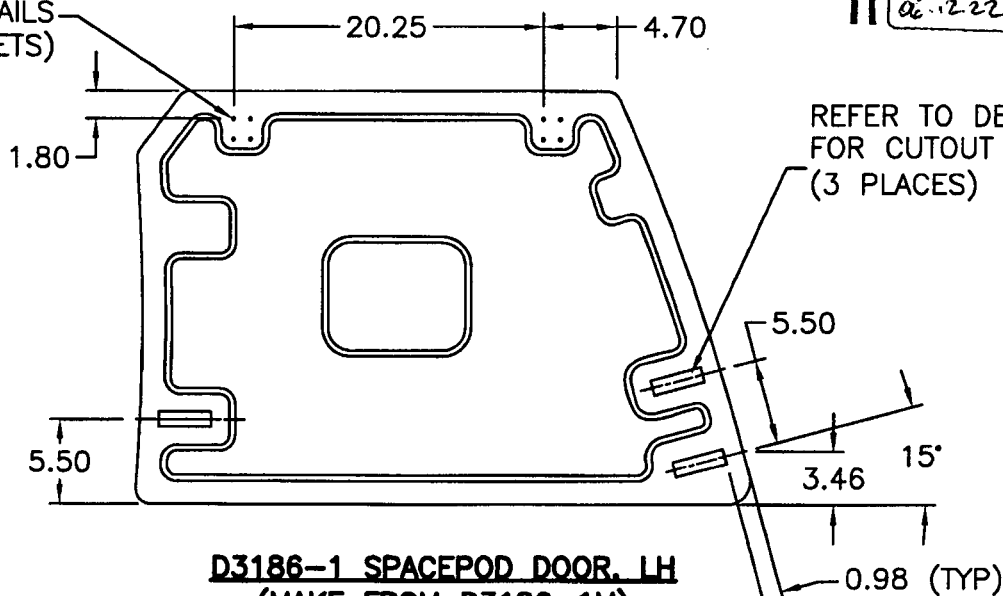
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 3 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
06.12.22 [Signature]

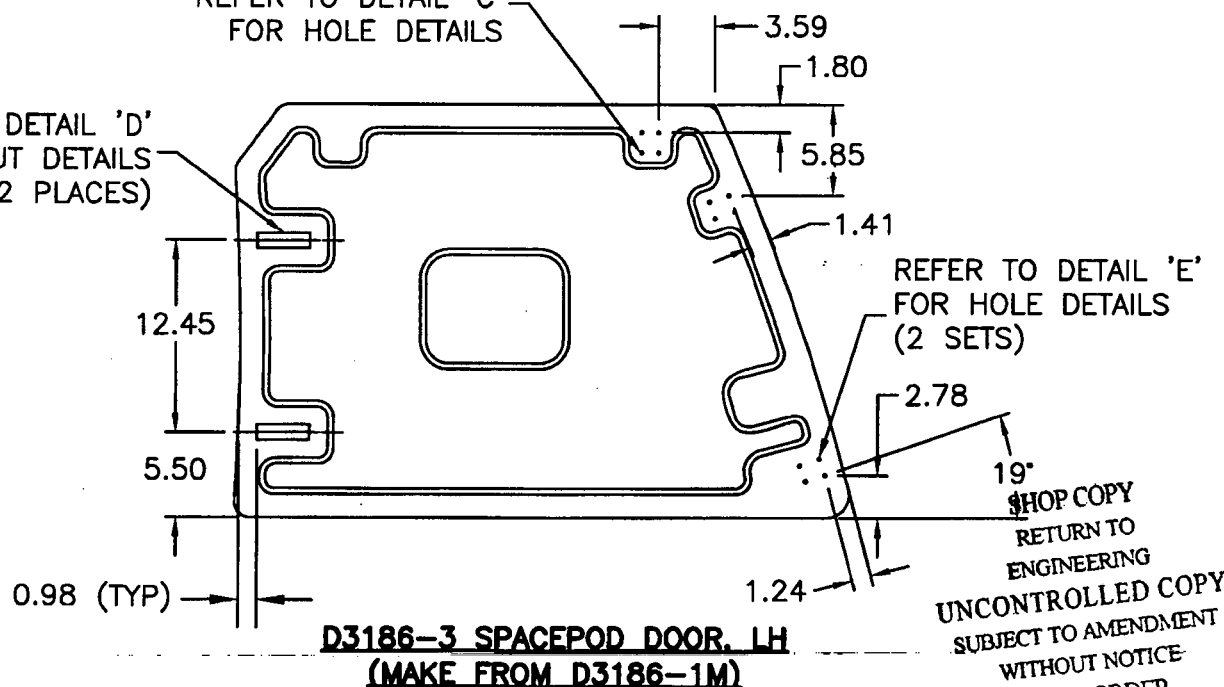
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FOR HOLE DETAILS
(2 SETS)



REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)

REFER TO DETAIL 'C'
FOR HOLE DETAILS

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)



REFER TO DETAIL 'E'
FOR HOLE DETAILS
(2 SETS)

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NO. 20017

NOTES:

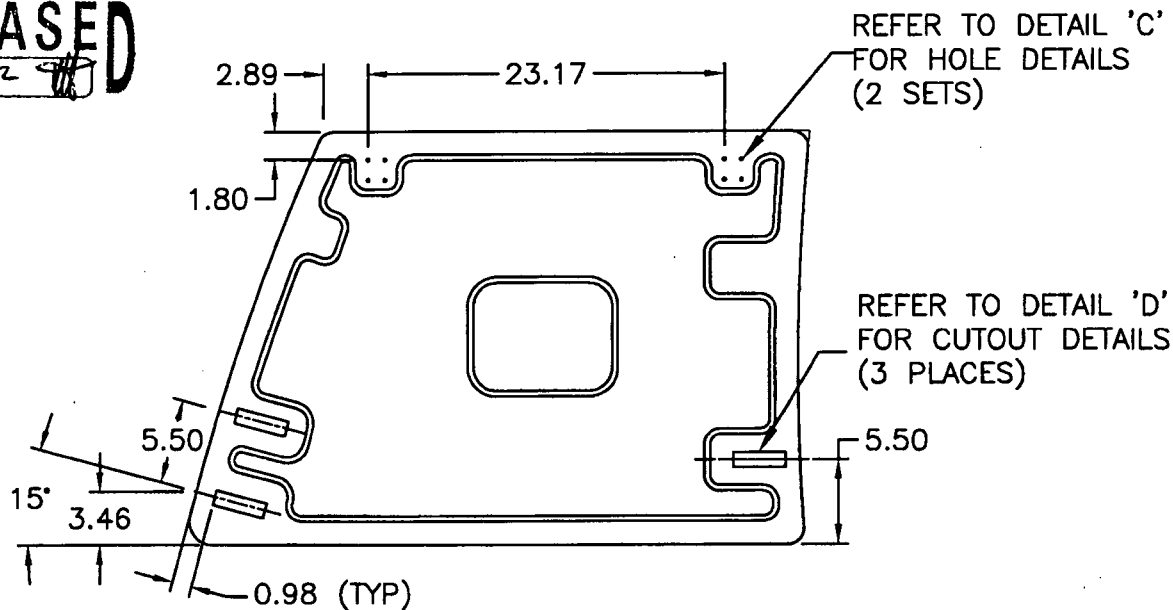
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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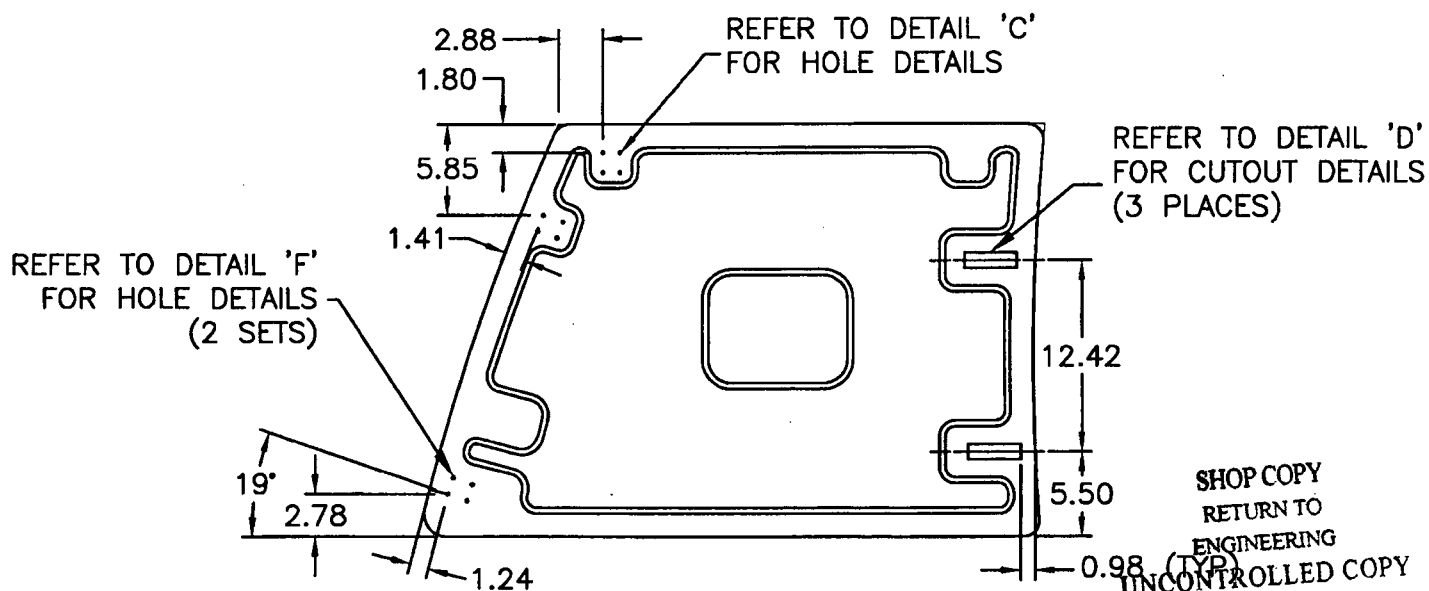
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 4 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
06.12.22

D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

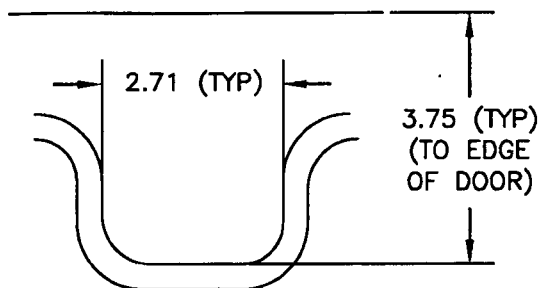
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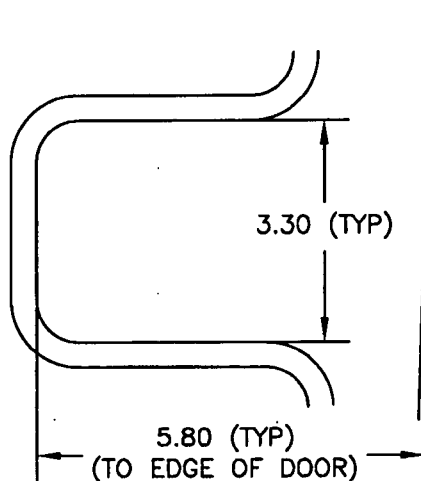
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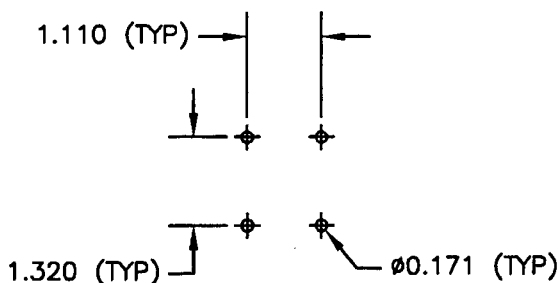
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 5 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



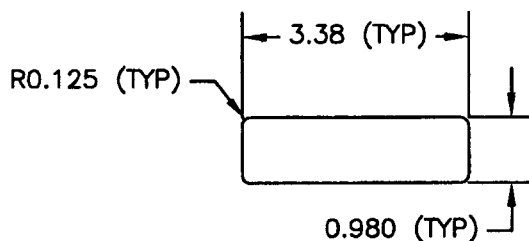
DETAIL A



DETAIL B

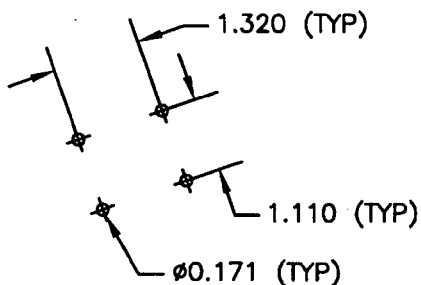


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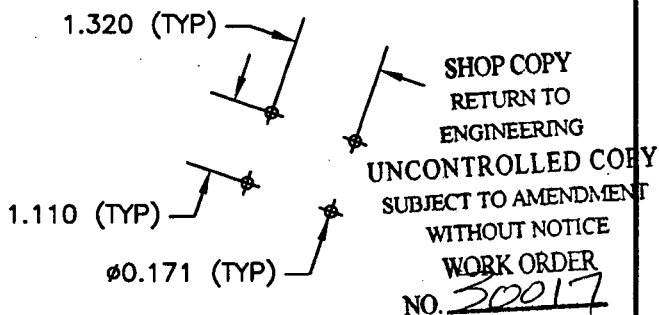


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RELEASED
06.12.22

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SWITCH RELOCATION KIT
Job Number	: 31080A		
Estimate Number	: 12778		
P.O. Number	: N/A	Part Number	: D350600449
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31078A	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: [Signature] 07.03.08		
Comment	: Est Rev'd 07.03.07 new issue ec		

Job Number:

1.0 DC DOCUMENT CONTROL

Comment: Photocopy bluefile & type labels per PPP D350-600-349 CHG001

2.0	M8182412	SPLICE
-----	----------	--------

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

SPLICE

batch: M103962 /

3.0	D35971	FEMALE SPADE CONNECTOR
-----	--------	------------------------

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

FEMALE SPADE CONNECTOR

batch: 13312004

4.0	D35982	EXPANDABLE SLEEVE 1/4"
-----	--------	------------------------

Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

EXPANDABLE SLEEVE 1/4"

cut 96" long

batch: ~~1103532~~ 1031450/

5.0	D35991	TIE WRAP
-----	--------	----------

Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

TIE WRAP

batch: 1331202 +

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SWITCH RELOCATION KIT

Job Number: 31080A

Part Number: D350600449

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36001

TIE WRAP MOUNT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

TIE WRAP MOUNT

batch: *B3/203+*

7.0

M2275916229

122GA ELECTRICAL WIRE, 120'



Comment: Qty.: 24.0000 ft(s)/Unit Total : 24.0000 ft(s)

122GA ELECTRICAL WIRE, 120'

Cut 24' feet long

batch: *M103532+*

7/03/22 SB

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CP 7/3/29 @ 10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-349

Location:

PPP Rev: *DMF+*

CP 7/3/29 @ 11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CP 7/3/30

Job Completion



U of 07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:35:30 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SWITCH RELOCATION KIT
Job Number	: 31084A		
Estimate Number	: 12778		
P.O. Number	: N/A	Part Number	: D350600449
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31083A	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>ADT.03.08</u>		
Comment	: Est Reva 07.03.07 new issue ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPP D350-600-349 CHG001

N/A

2.0	M8182412	SPLICE
-----	----------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

SPLICE
batch: M103962 /

3.0	D35971	FEMALE SPADE CONNECTOR
-----	--------	------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

FEMALE SPADE CONNECTOR
batch: B31200 ✓

4.0	D35982	EXPANDABLE SLEEVE 1/4"
-----	--------	------------------------



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

EXPANDABLE SLEEVE 1/4"
cut 96" long
batch: M103532 B31438 ✓

5.0	D35991	TIE WRAP
-----	--------	----------



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

TIE WRAP
batch: B31202 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 07/03/30

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:35:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SWITCH RELOCATION KIT

Job Number: 31084A

Part Number: D350600449

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36001

TIE WRAP MOUNT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
TIE WRAP MOUNT
batch: 55/203 ✓

7.0

M2275916229

122GA ELECTRICAL WIRE, 120'



Comment: Qty.: 24.0000 ft(s)/Unit Total : 24.0000 ft(s)
122GA ELECTRICAL WIRE, 120'
Cut 24' feet long
batch: M103532 ✓

7/03/22 SP

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6/27/25

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-600-349
Location: _____
PPP Rev: 07/03/29 (1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/30 (1)

Job Completion



U 07/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:45:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY LH
Job Number	: 30027		
Estimate Number	: 12595		
P.O. Number	: <i>N/A</i>	Part Number	: D31881M
This Issue	: 12/20/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3188 REV <i>BC</i> <i>07.01.18</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: <i>BC</i> <i>07.01.18</i>
Previous Run	: 30026	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 2/5/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i> <i>061220</i>		
Comment	: Est Rev:A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8 D2213 Spacer Batch: *B25325* *C2010103* (8)

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
 Issue P/O: *2767*
 Description: D3188-1 BODY *C206112121*
 Ship: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

07/3/22 (U)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 7 Date: 07/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:45:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY_LH

Job Number: 30027

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

ml 07/03/26

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/03/26

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
P 07/03/30

Job Completion



W 07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	REV. C
DATE 06.12.13	TITLE SPACEPOD BODY	SHEET 1 OF 11
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

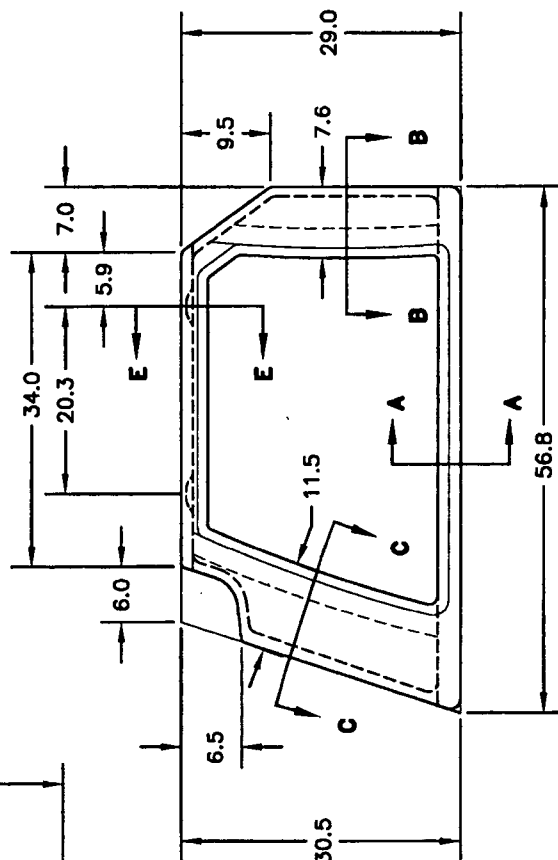
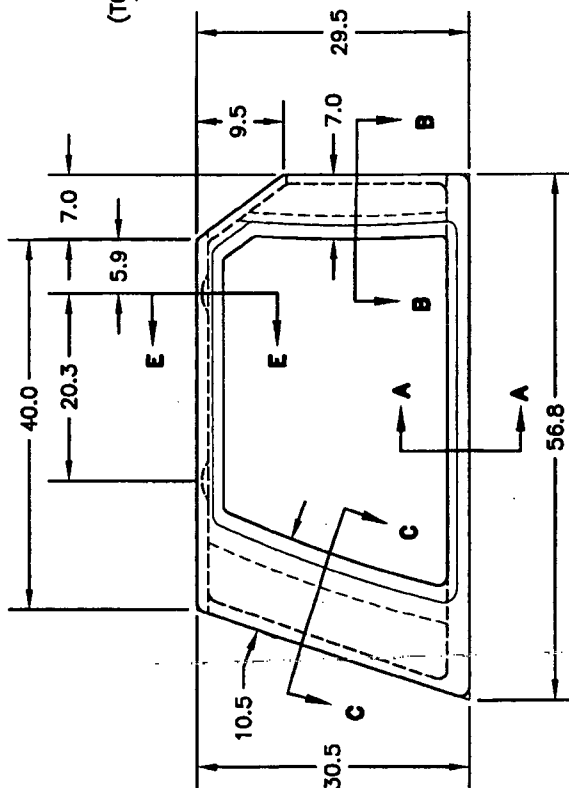
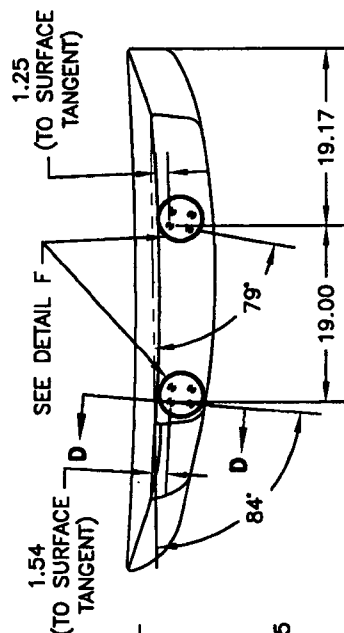
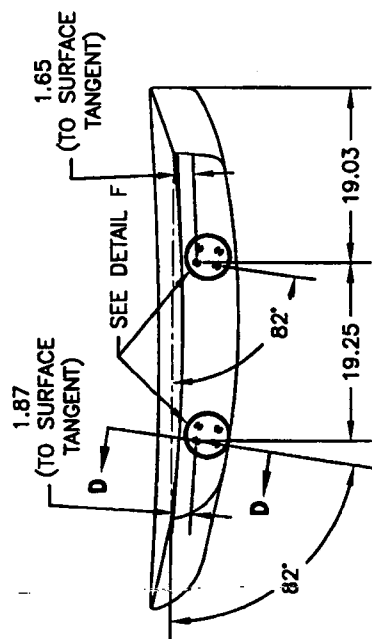
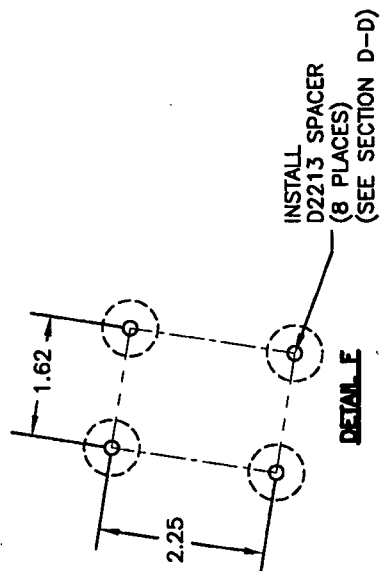
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

**D3188-3M SPACEPOD BODY****D3188-1M SPACEPOD BODY**

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DATE **06.12.2013**

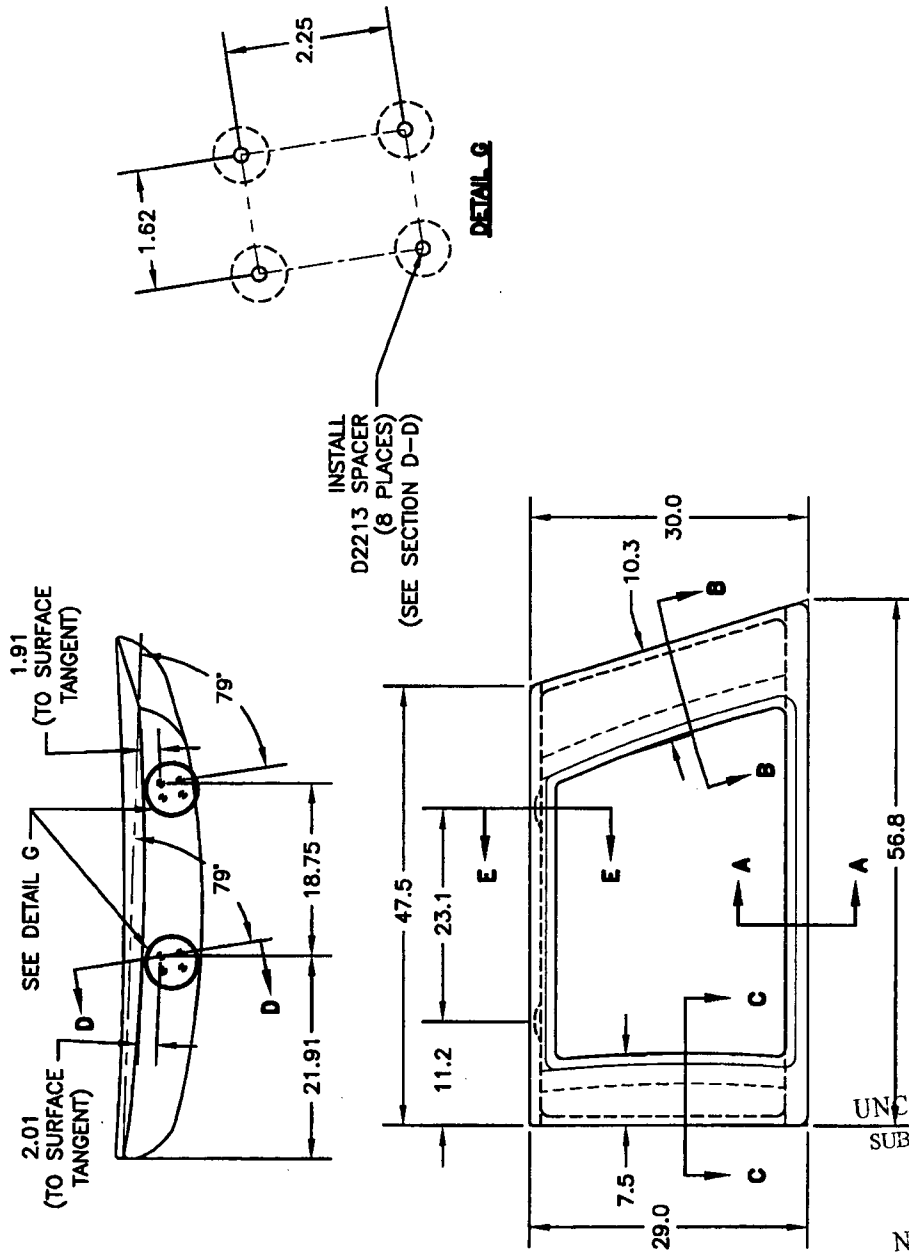
SEE SHEET #4 FOR SECTION VIEWS

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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS



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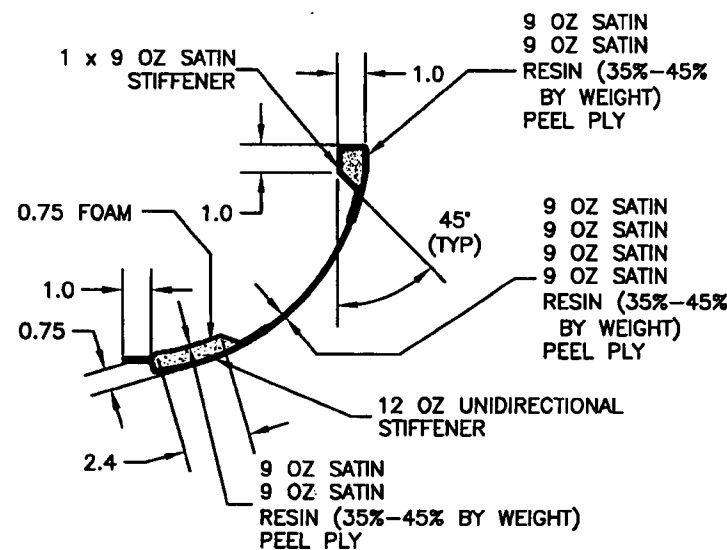
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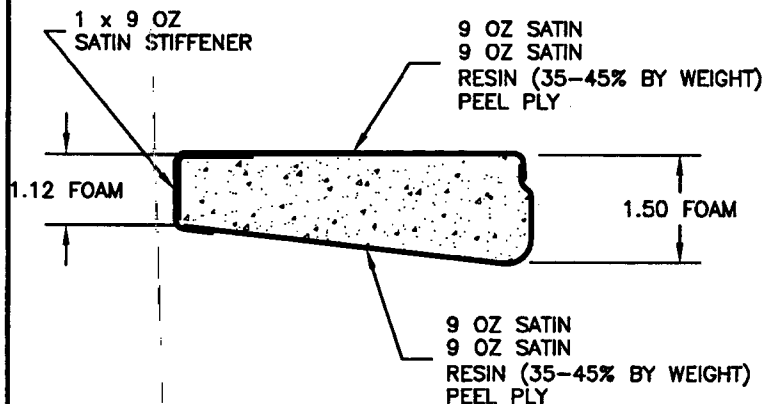
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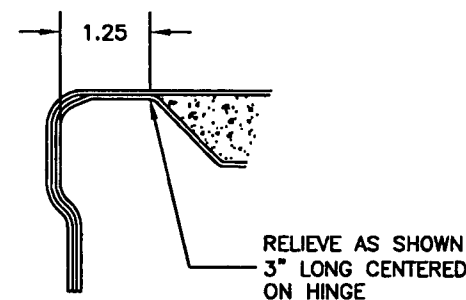
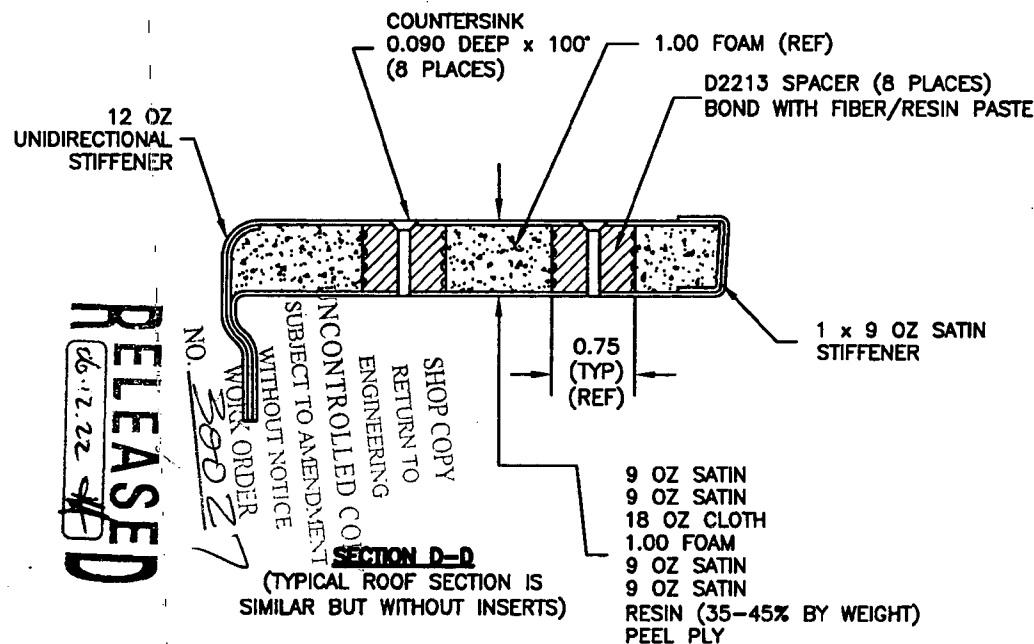
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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA	
DATE	06.12.13	DRAWING NO.	D3188	REV. C	
TITLE	SPACEPOD BODY	SHEET 4 OF 11		SCALE	
				NIS	



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION E-E
(2 PLACES PER POD)

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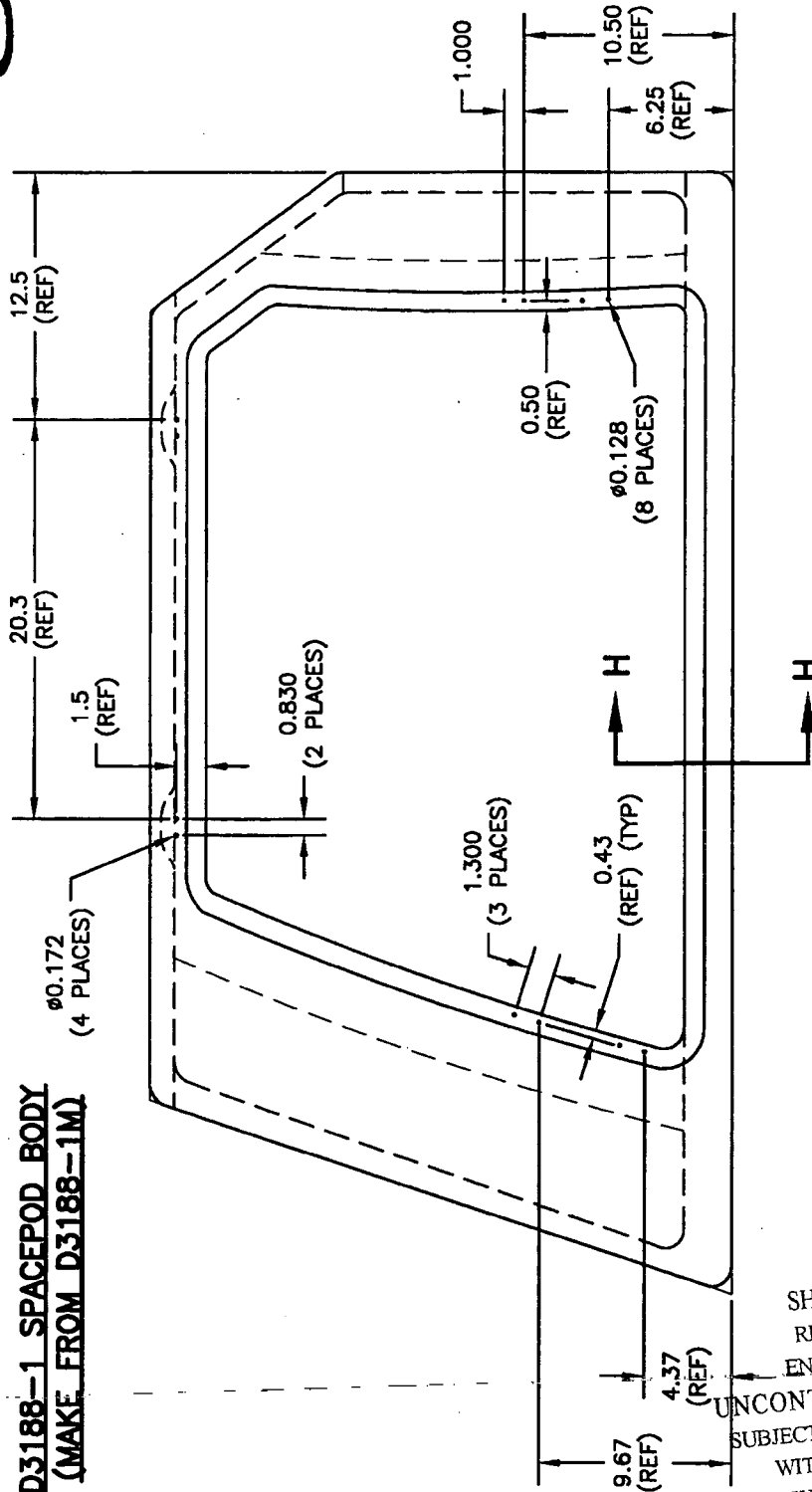
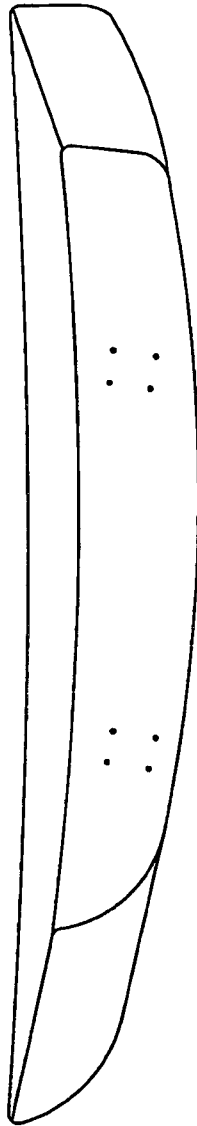
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

- NOTES:**
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEW

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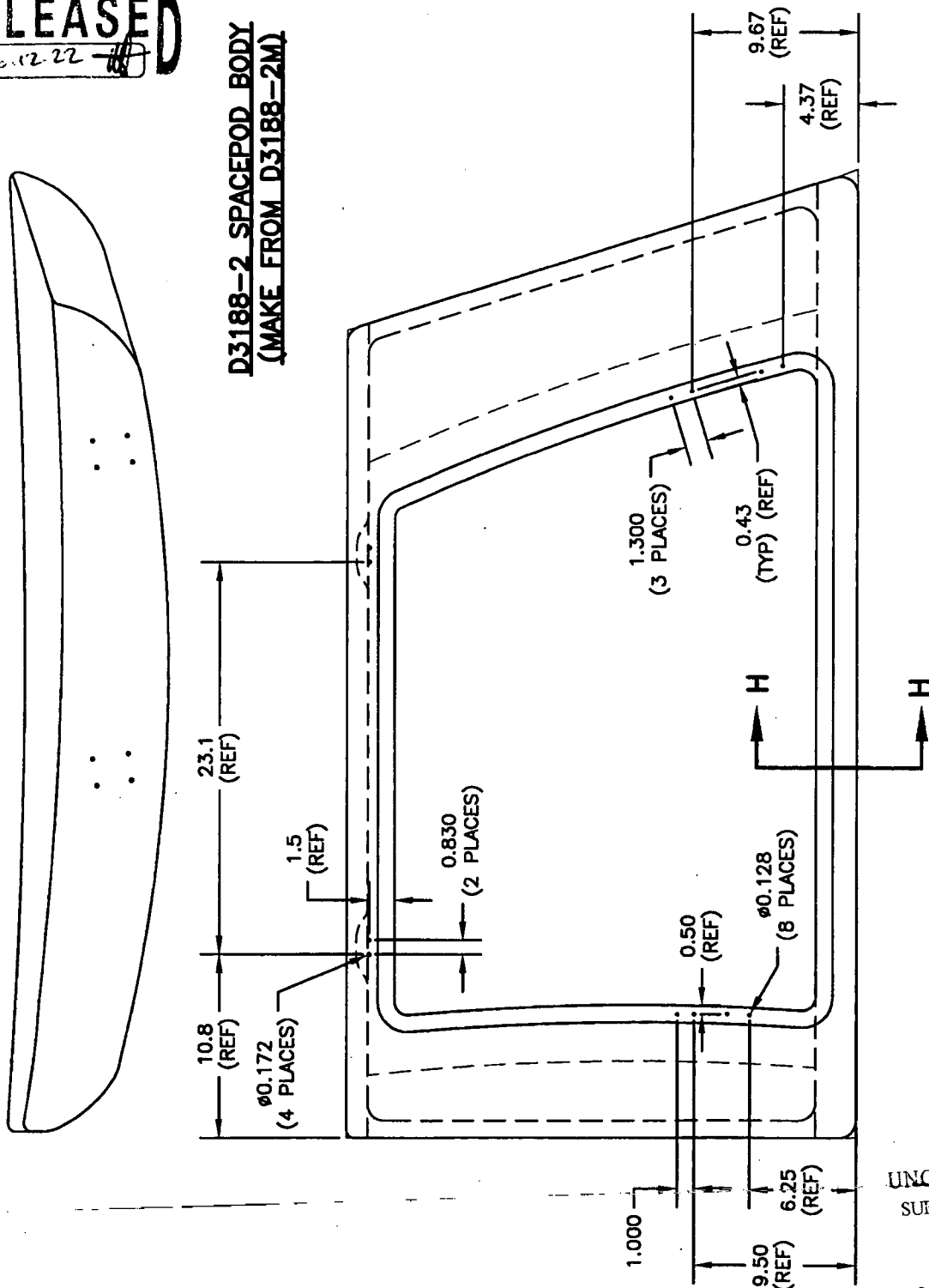
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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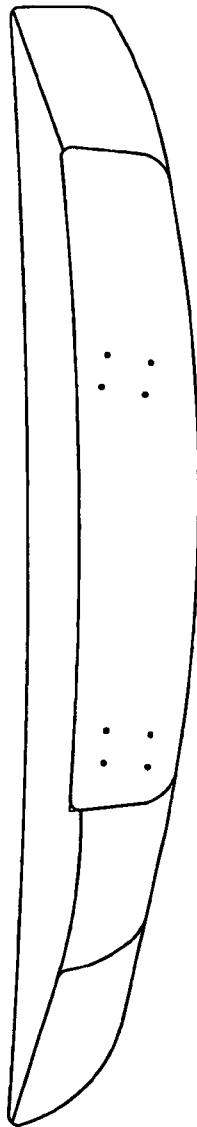
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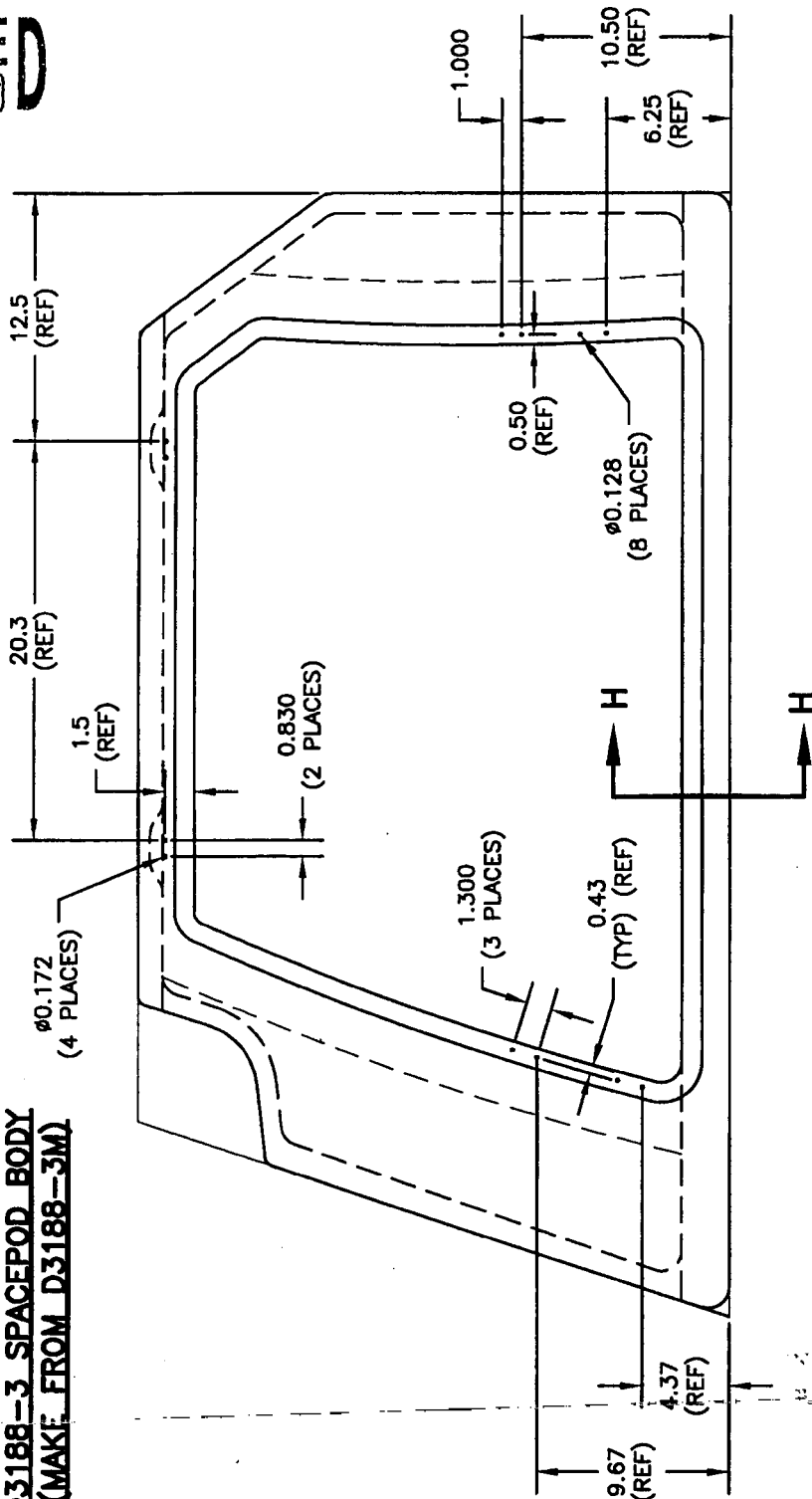


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22



D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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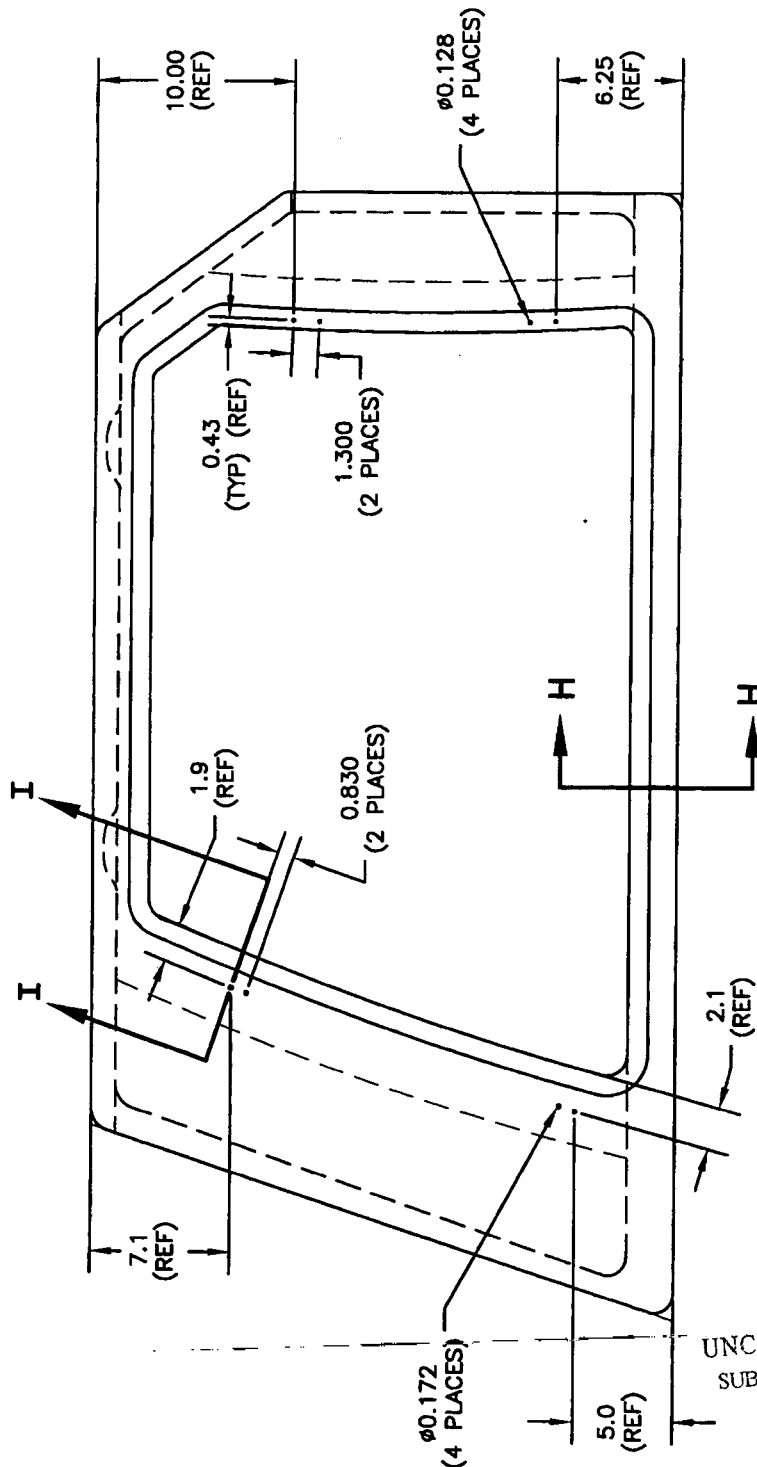
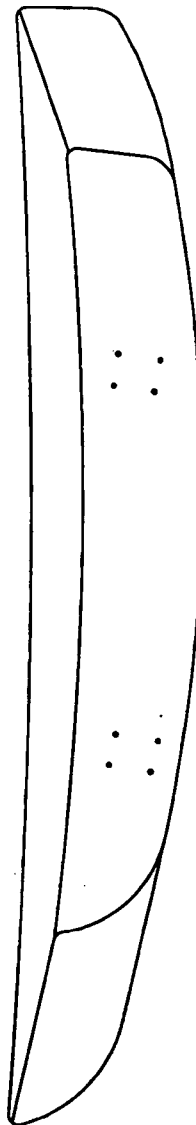
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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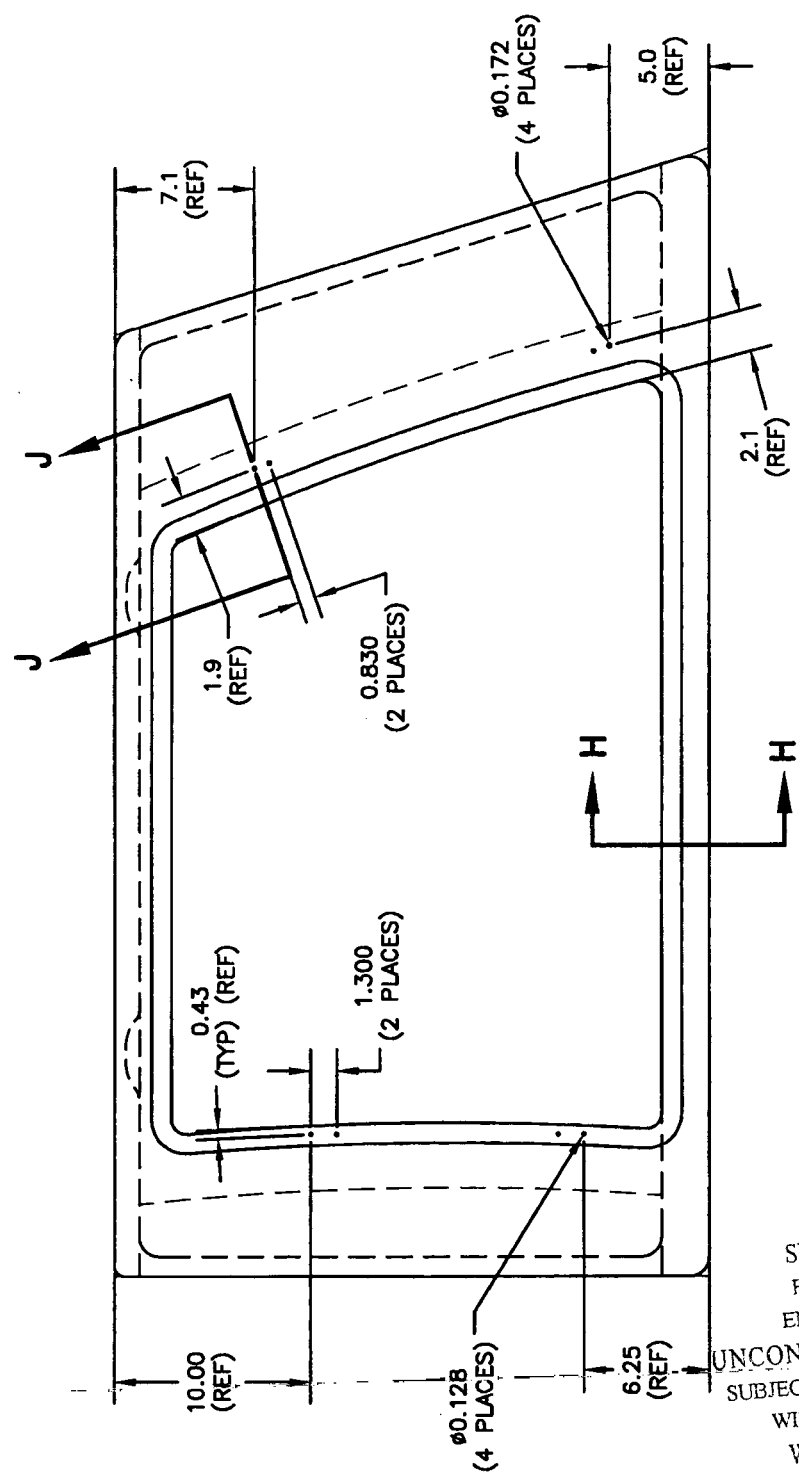
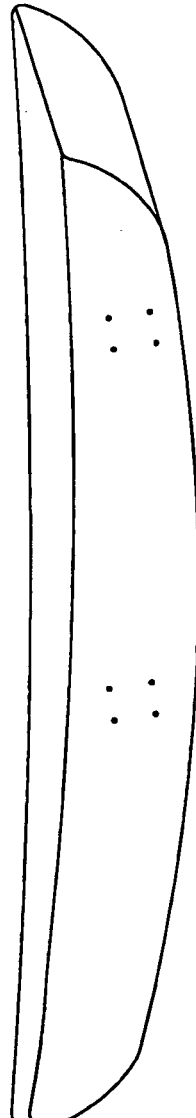
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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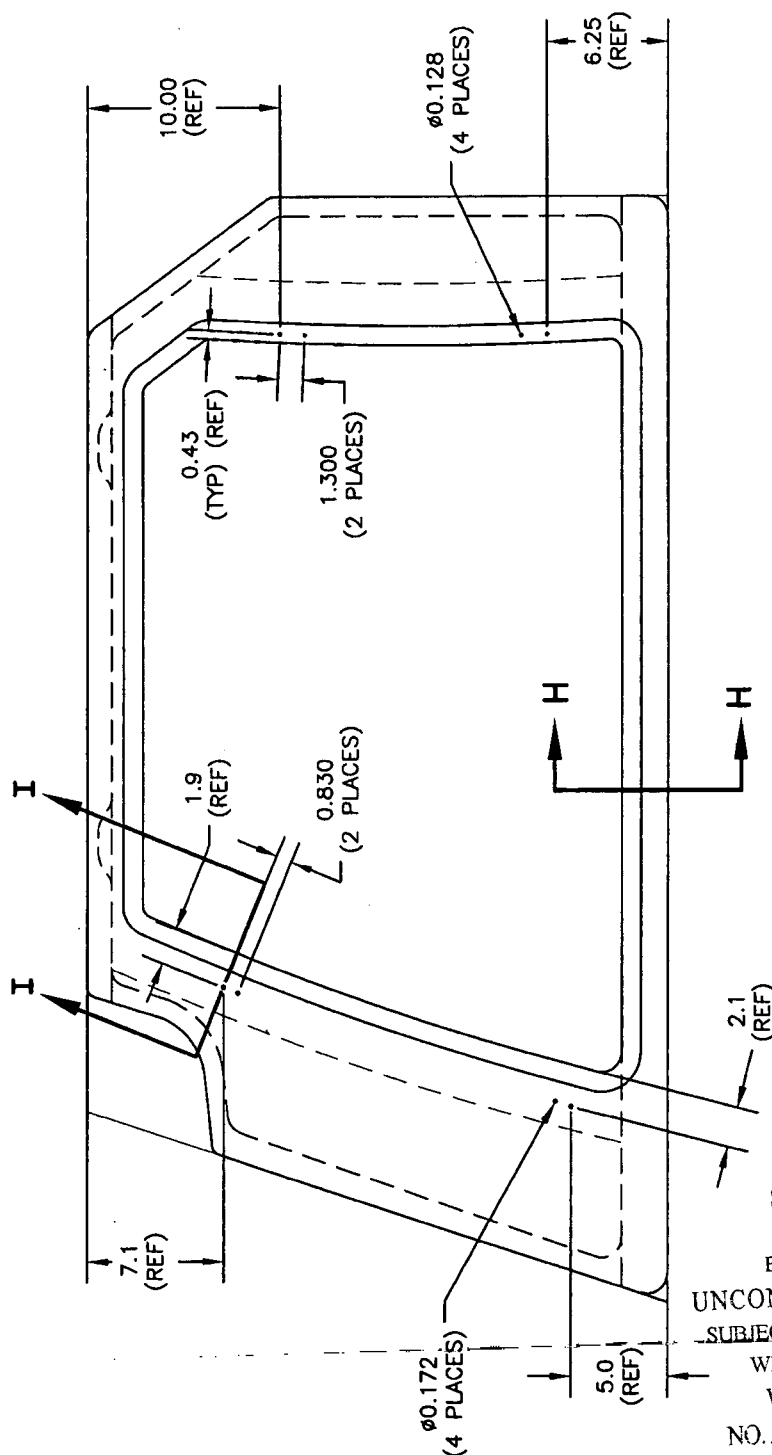
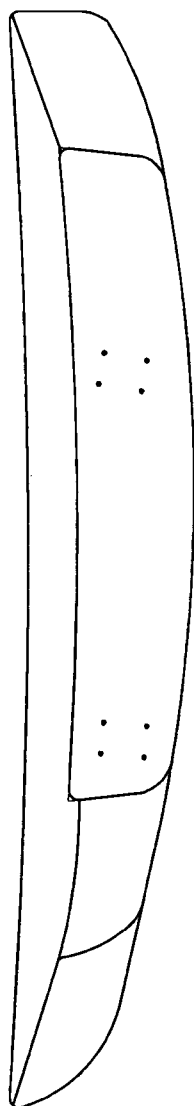
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

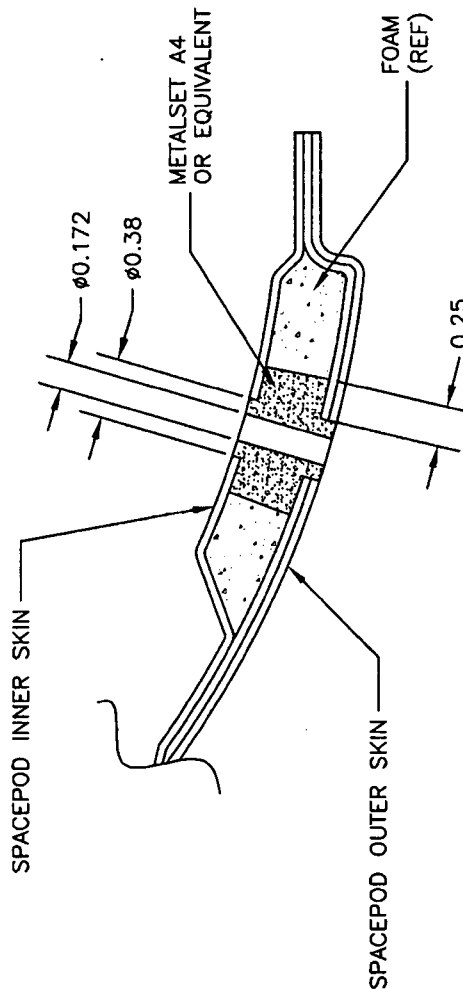
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06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Wednesday, 3/7/2007 4:28:28 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 31080C01		
Estimate Number	: 12598		
P.O. Number	:	Part Number	: D31861M
This Issue	: 3/7/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31078C01	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.03.08</u>		
Comment	: Est Rev: A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
Issue P/O: _____
Description: D3186-1M Door
Supplier: Delastek
Conformity Certificate and Process sheet required

replaced by 4030017

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins. Ensure surface of doo is smooth, no dimples for drilling.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:28:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 31080C01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



EL 07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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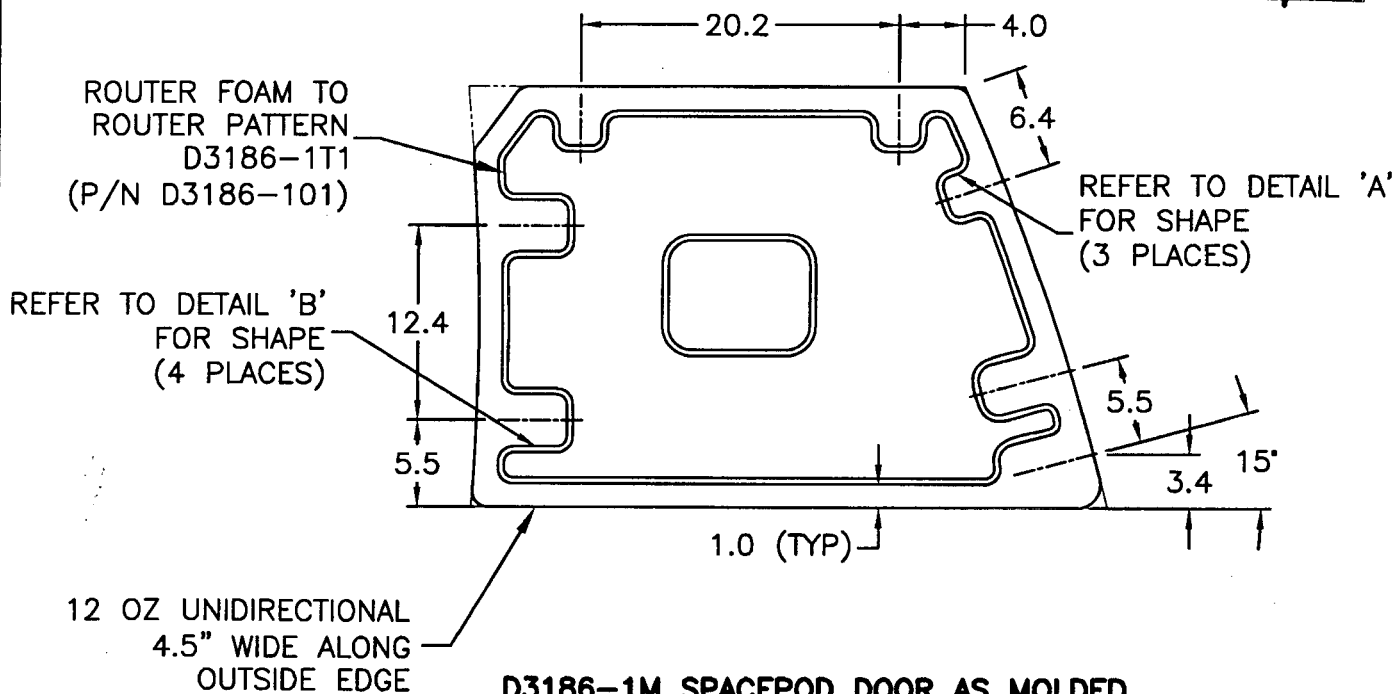
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERA KANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4:0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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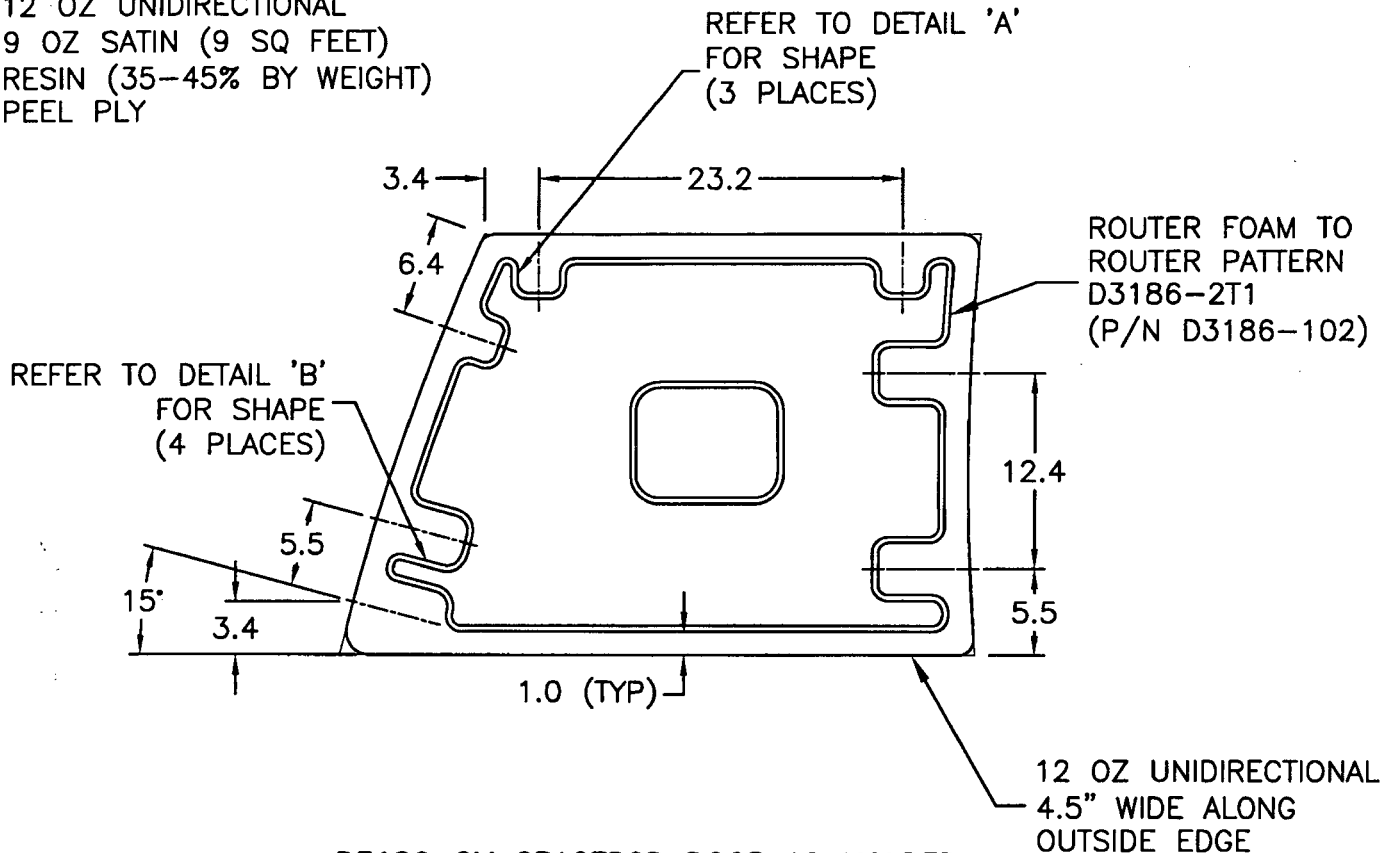
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 [Signature]

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI-006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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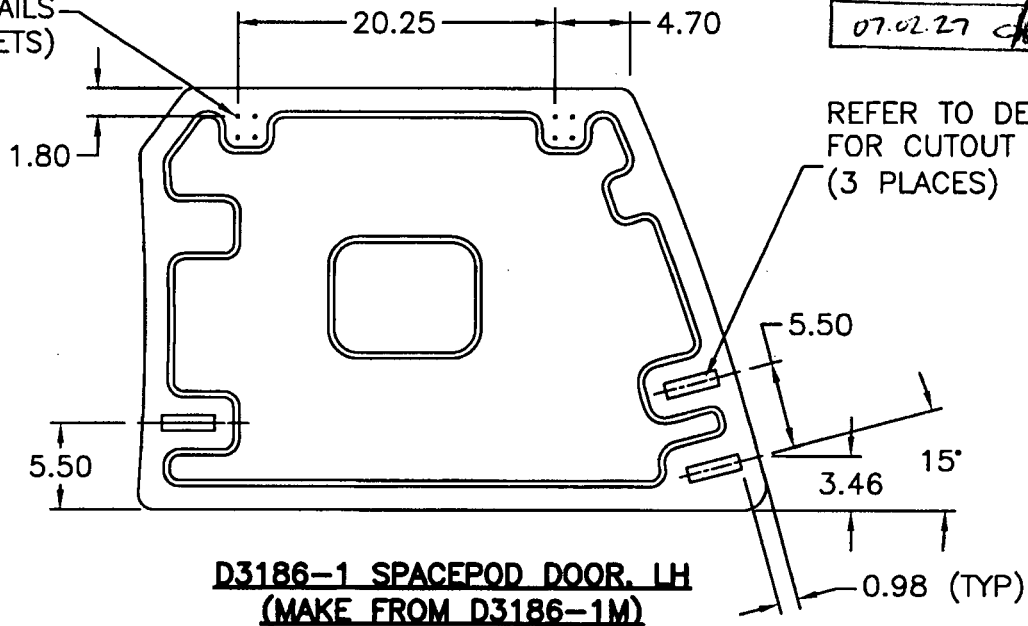
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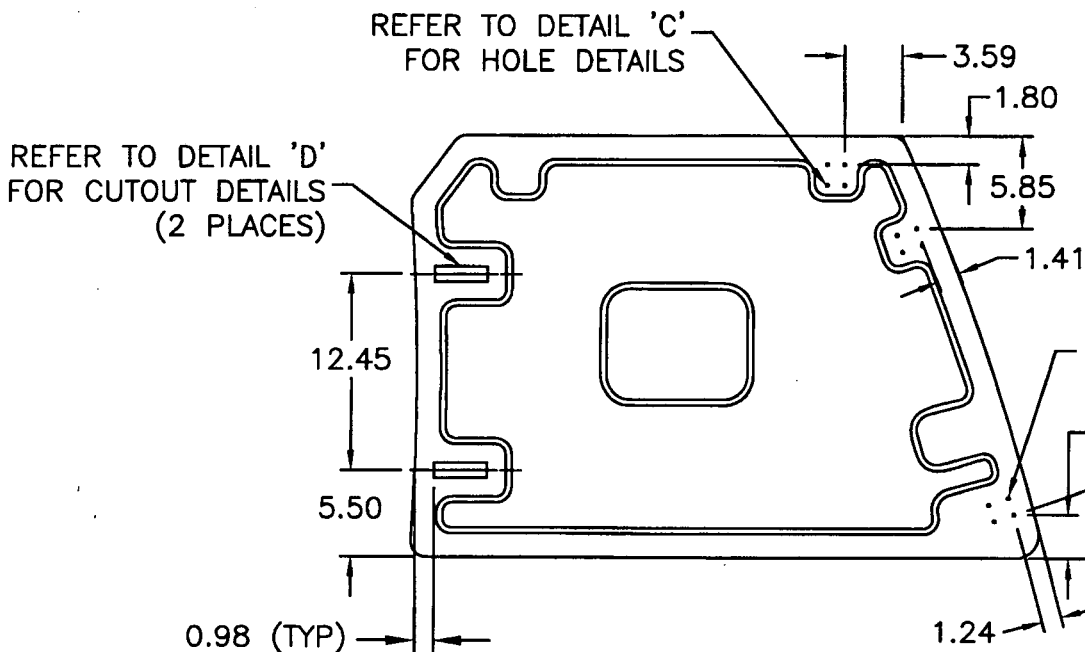
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)



REFER TO DETAIL 'E'
FOR HOLE DETAILS
(2 SETS)

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NOTES:

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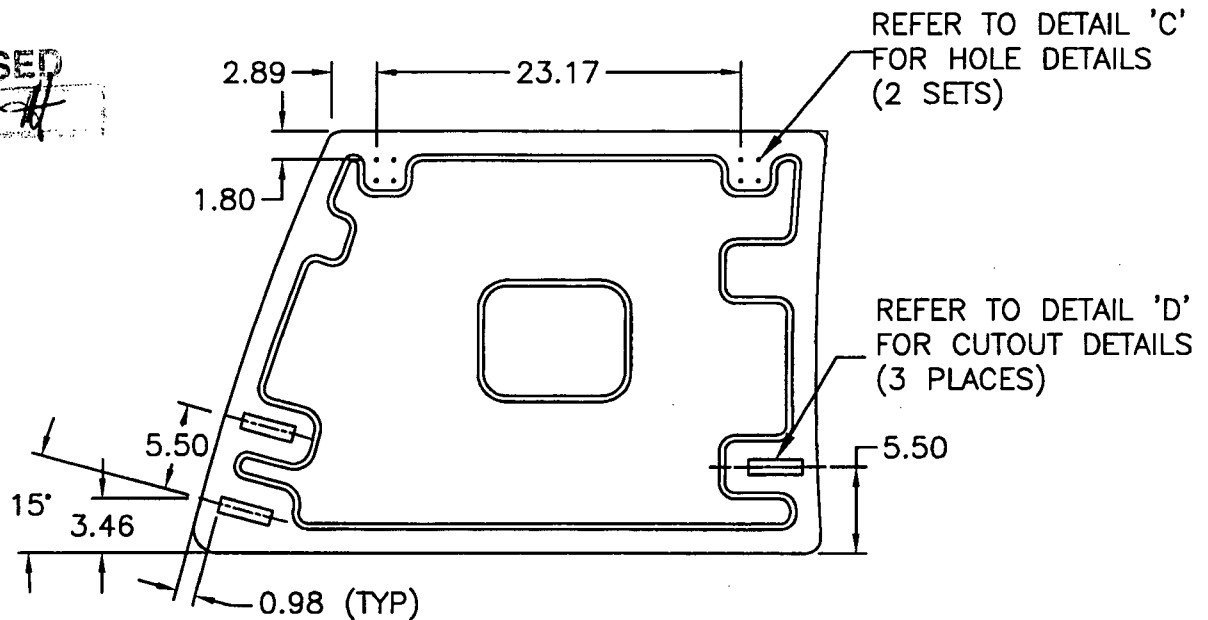
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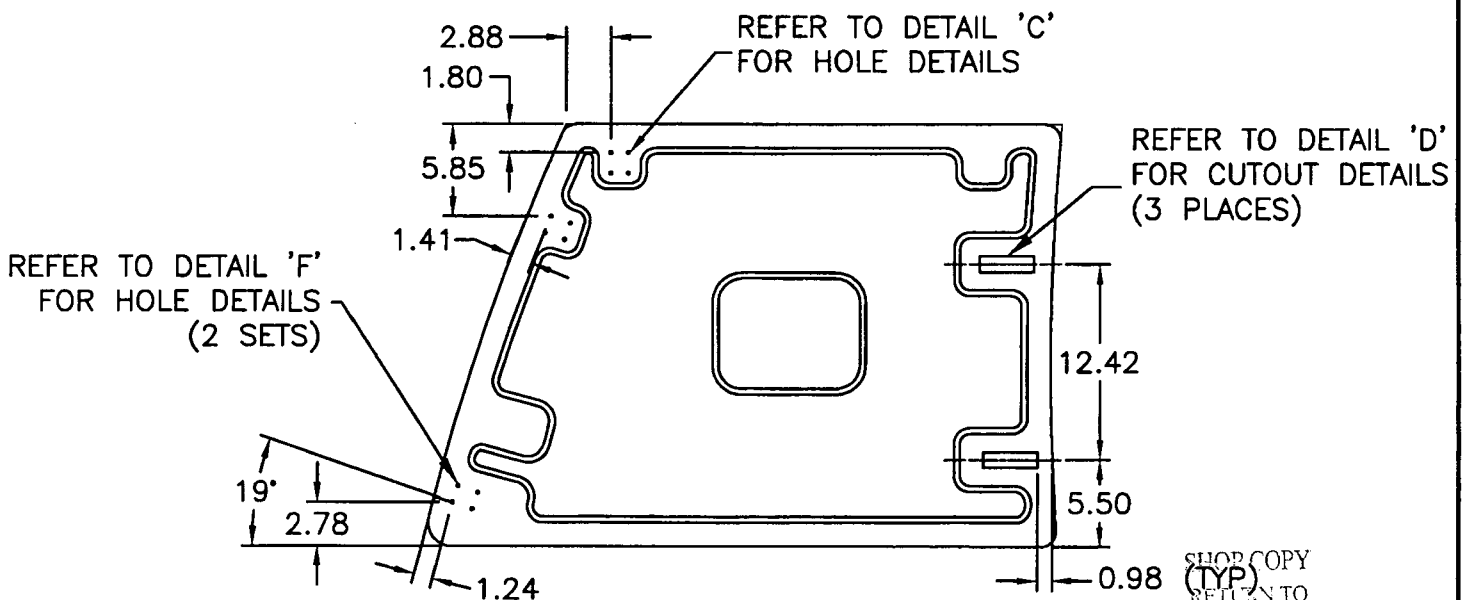
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

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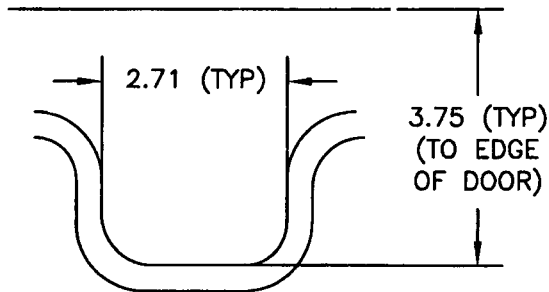
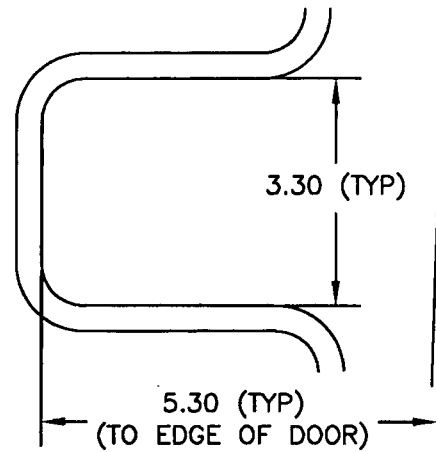
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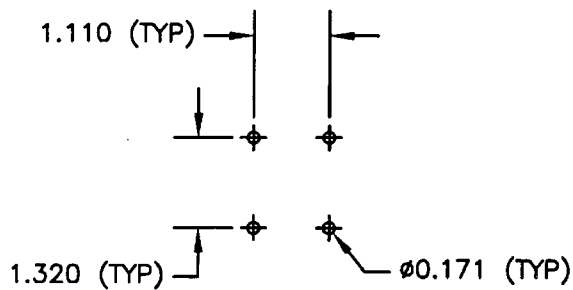
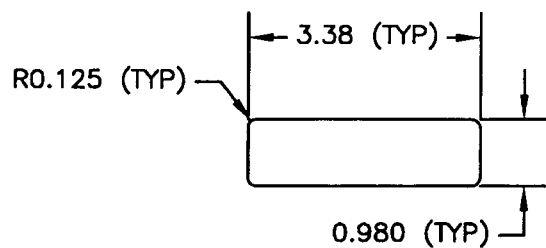
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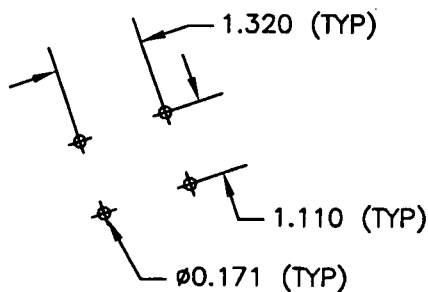
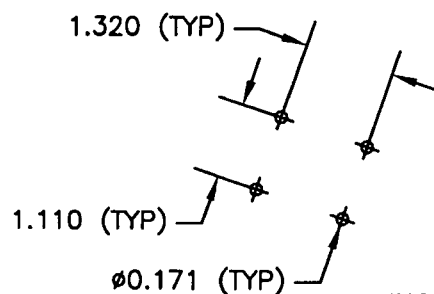
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**DETAIL A****DETAIL B****RELEASED**

07.02.27 [Signature]

**DETAIL C**

NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F****NOTES:**

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Date: Wednesday, 3/7/2007 4:28:25 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY LH
Job Number	: 31080B		
Estimate Number	: 12595		
P.O. Number	:	Part Number	: D31881M
This Issue	: 3/7/2007 S.O. No. :	Drawing Number	: D3188
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31078B	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>3/07.03.08</u>		
Comment	: Est Rev: A New issue ecn882 06/11-30 EC est rev B revc dwg 07.01.11 ec		

Additional Product

Job Number:



replaced by

Seq. #: Machine Or Operation: Description :

1.0 D2213 Aluminum Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8 D2213 Spacer Batch: _____

2/00/08
w/030027

2.0 PG PURCHASING



Comment: PURCHASING
Issue P/O: _____
Description: D3188-1M BODY
Ship: D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

3.0 D31881P Spacepod Body



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:28:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 31080B

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 27.03.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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JB	CE		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 11
		D3188	
DATE		TITLE	SCALE
07.02.22		SPACEPOD BODY	MTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

RELEASED

07.02.22

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES

8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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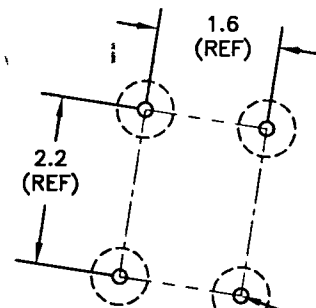
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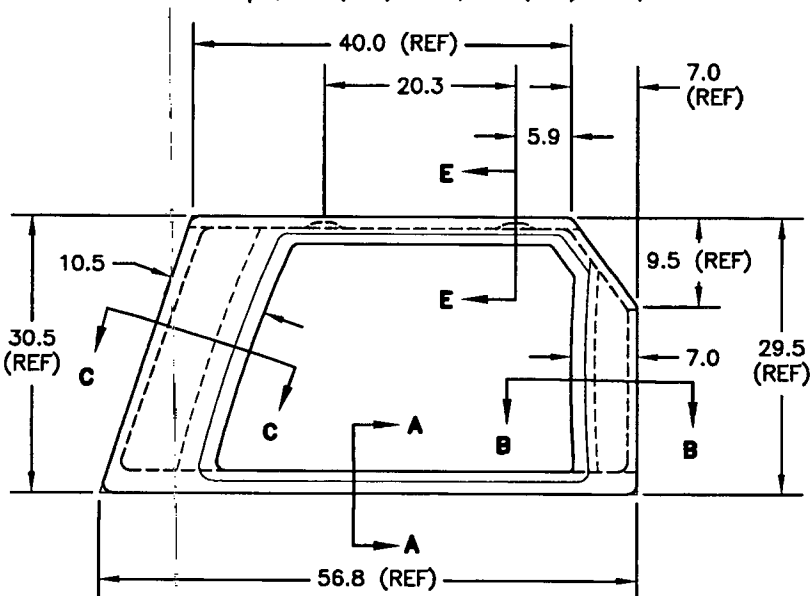
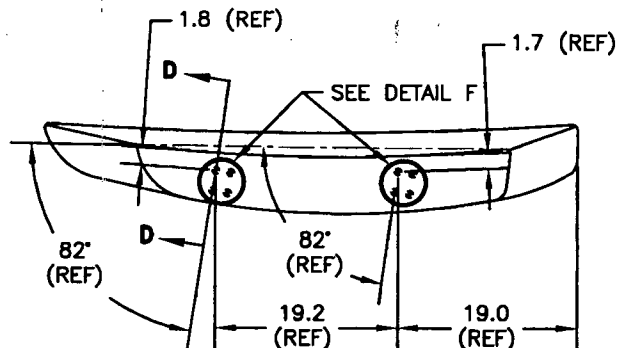
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DATE	07.02.22			D3188	SHEET 2 OF 11
				TITLE	SCALE
				SPACEPOD BODY	NTS

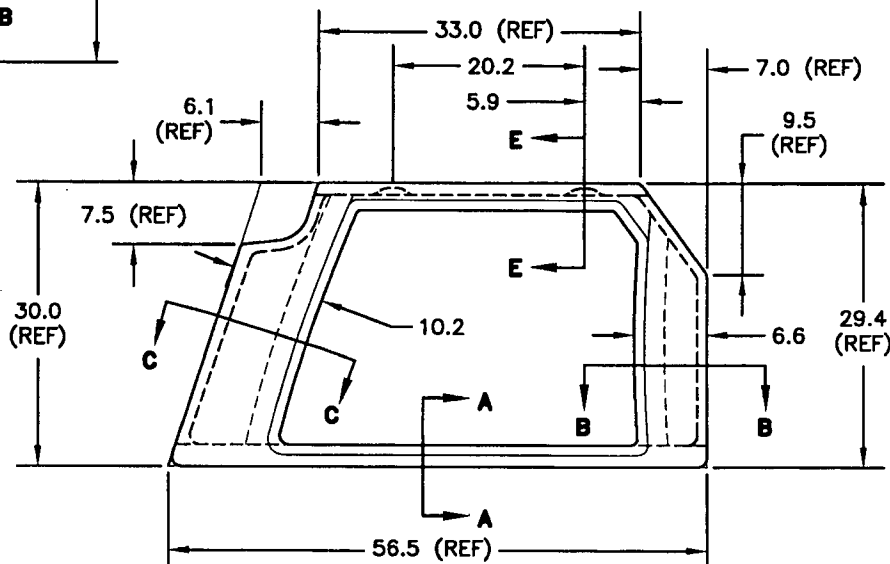
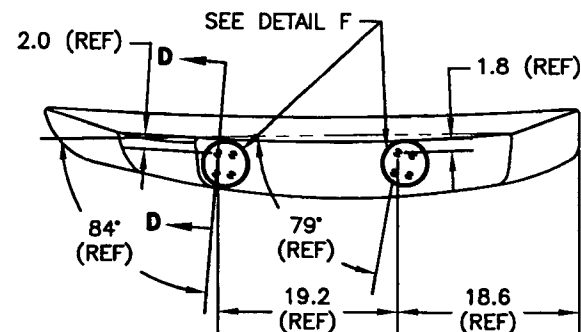


DETAIL F

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

D3186-1M/-3M NOTES:

1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.

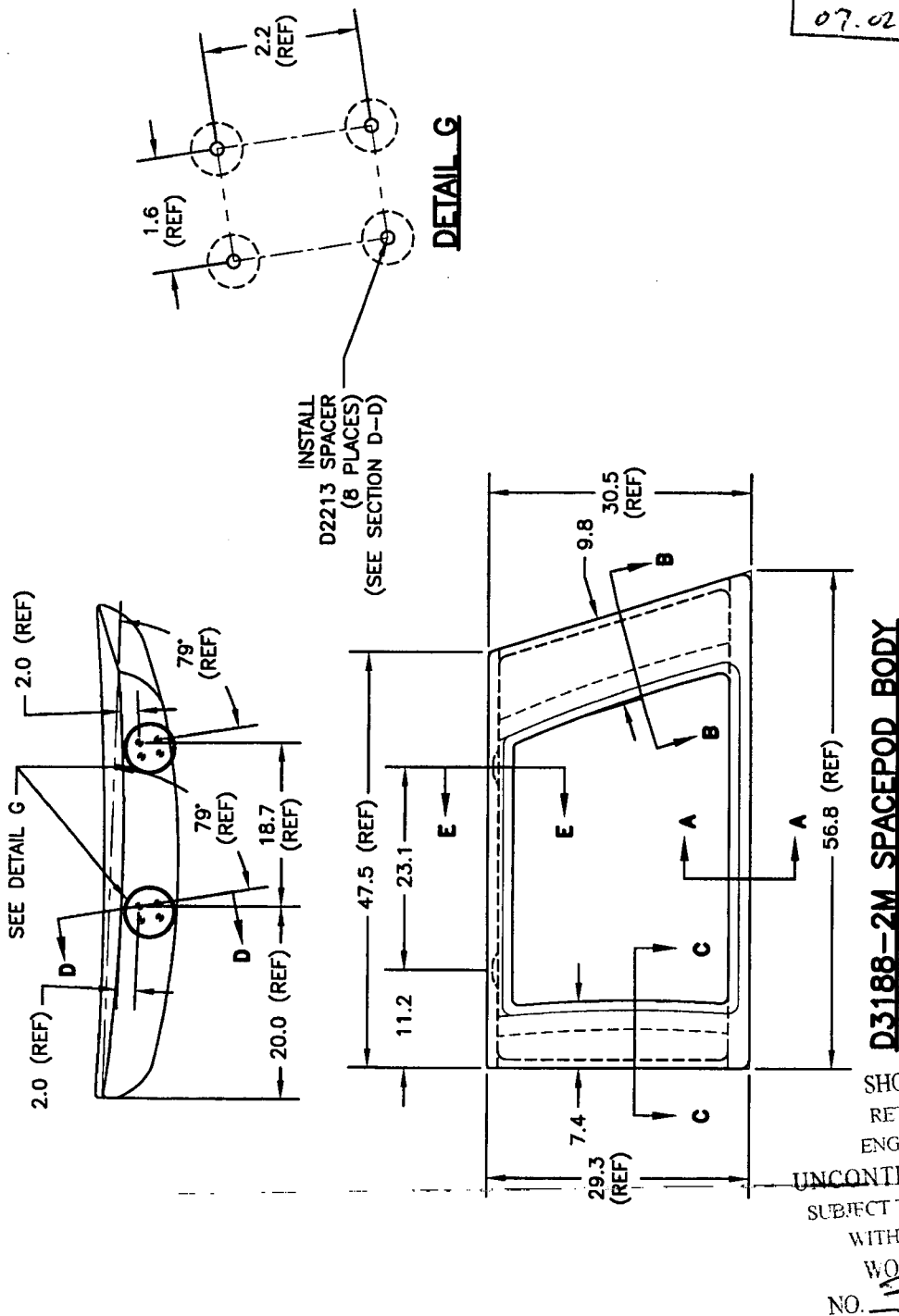
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DATE 07.02.22		TITLE SPACEPOD BODY	SCALE NTS

RELEASED**07.02.27**

D3188-2M NOTES:
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2. SEE SHEET #4 FOR SECTION VIEWS.

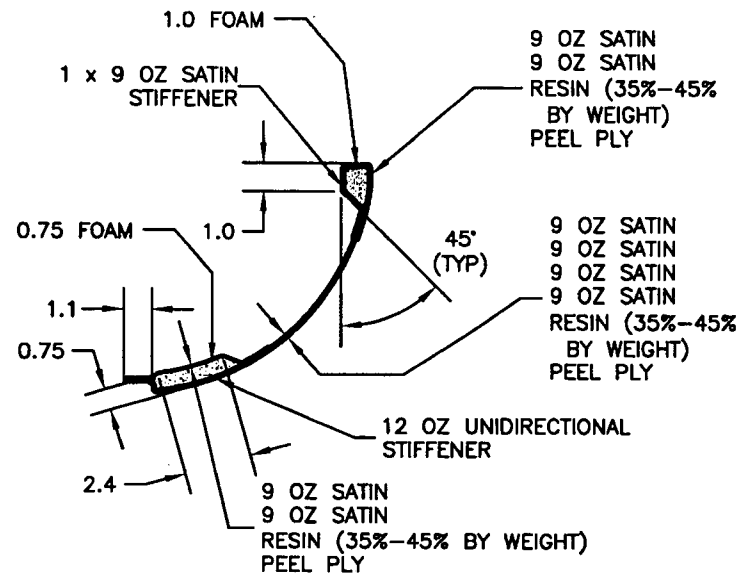
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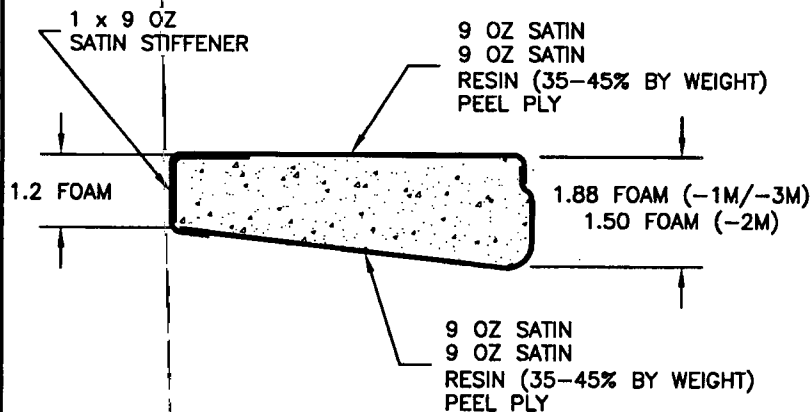
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DATE	07.02.22	TITLE	SPACEPOD BODY	REV. D
				SHEET 4 OF 11
				SCALE NTS

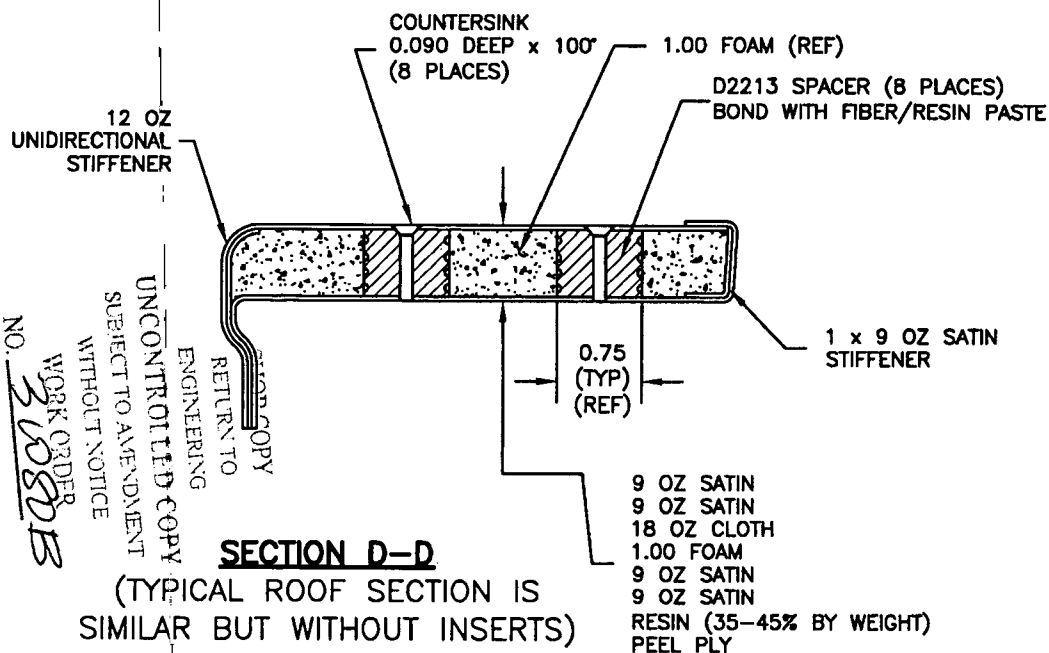
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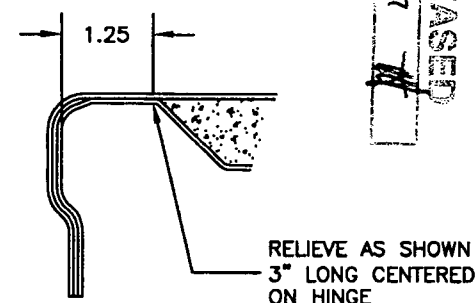
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

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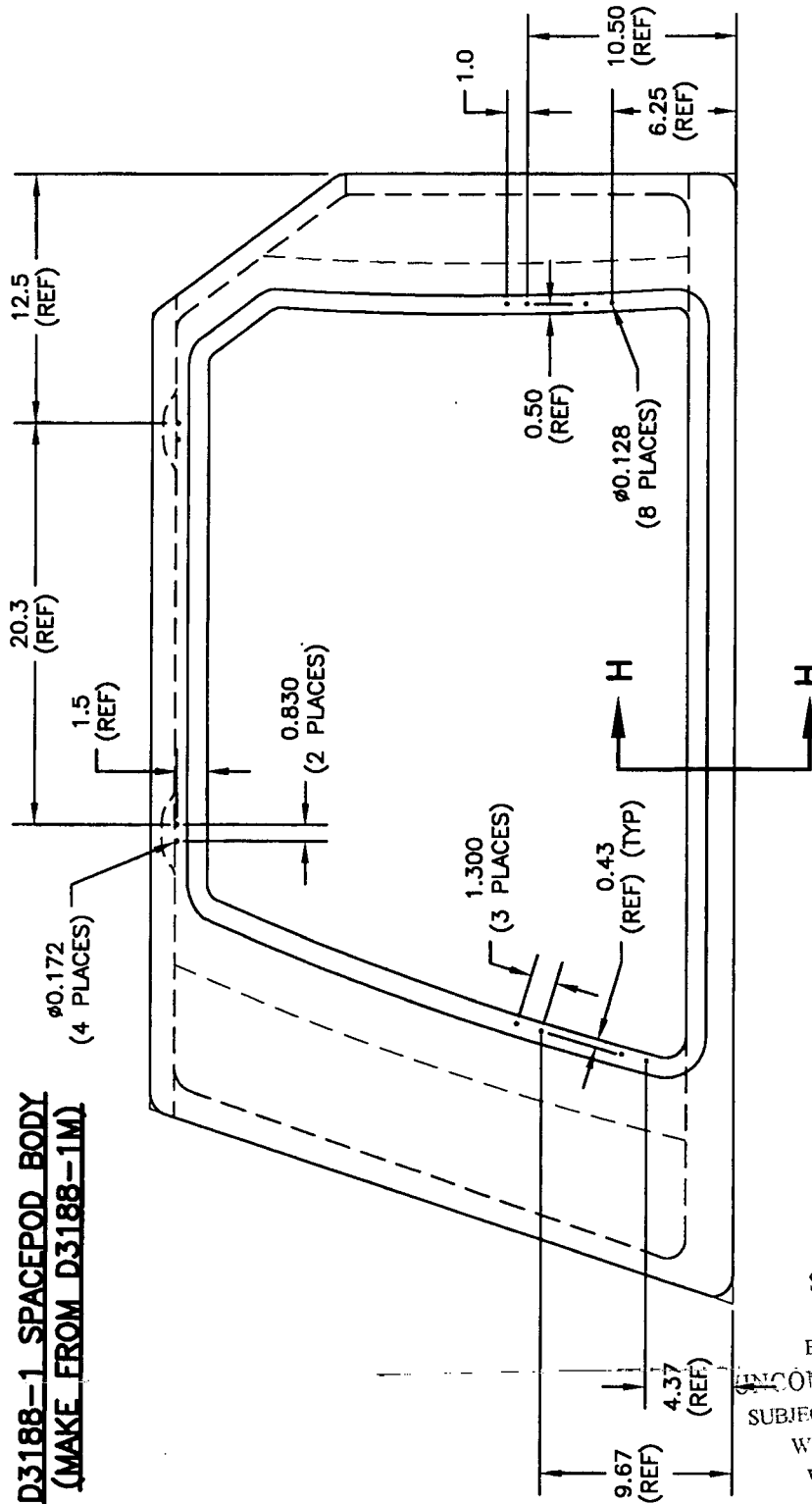
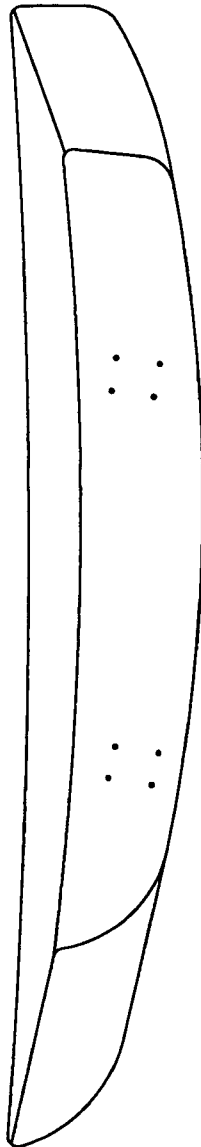
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07-02-27



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEW

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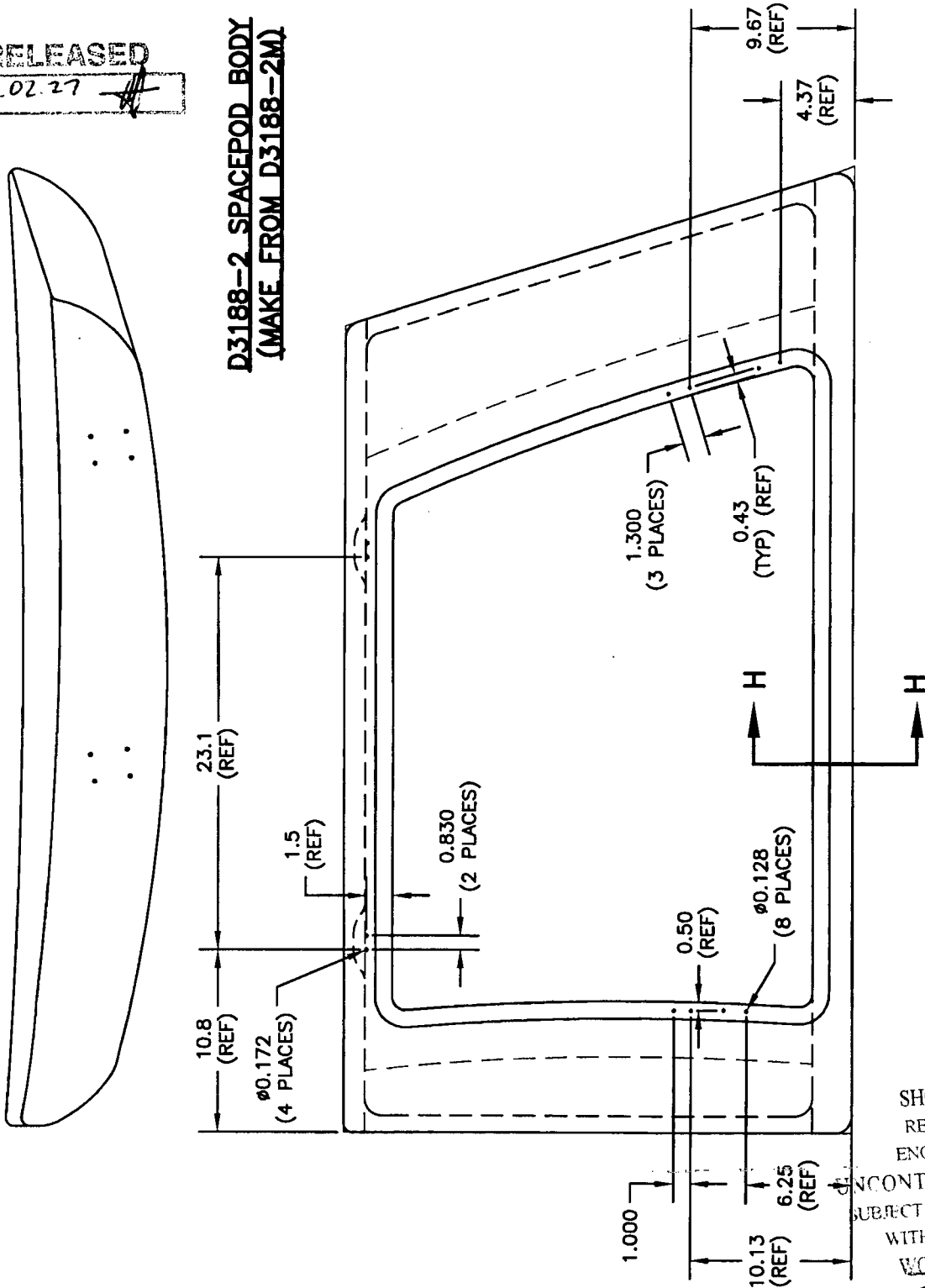
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07.02.27

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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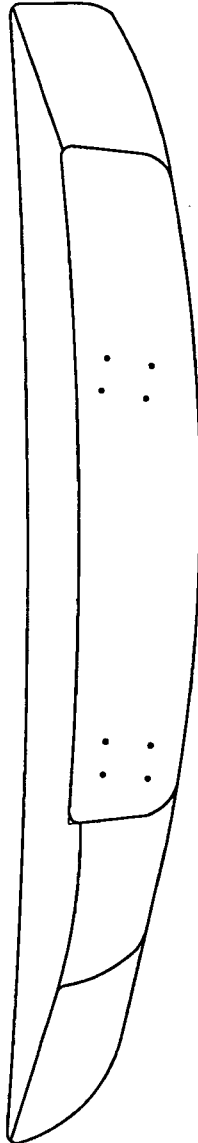
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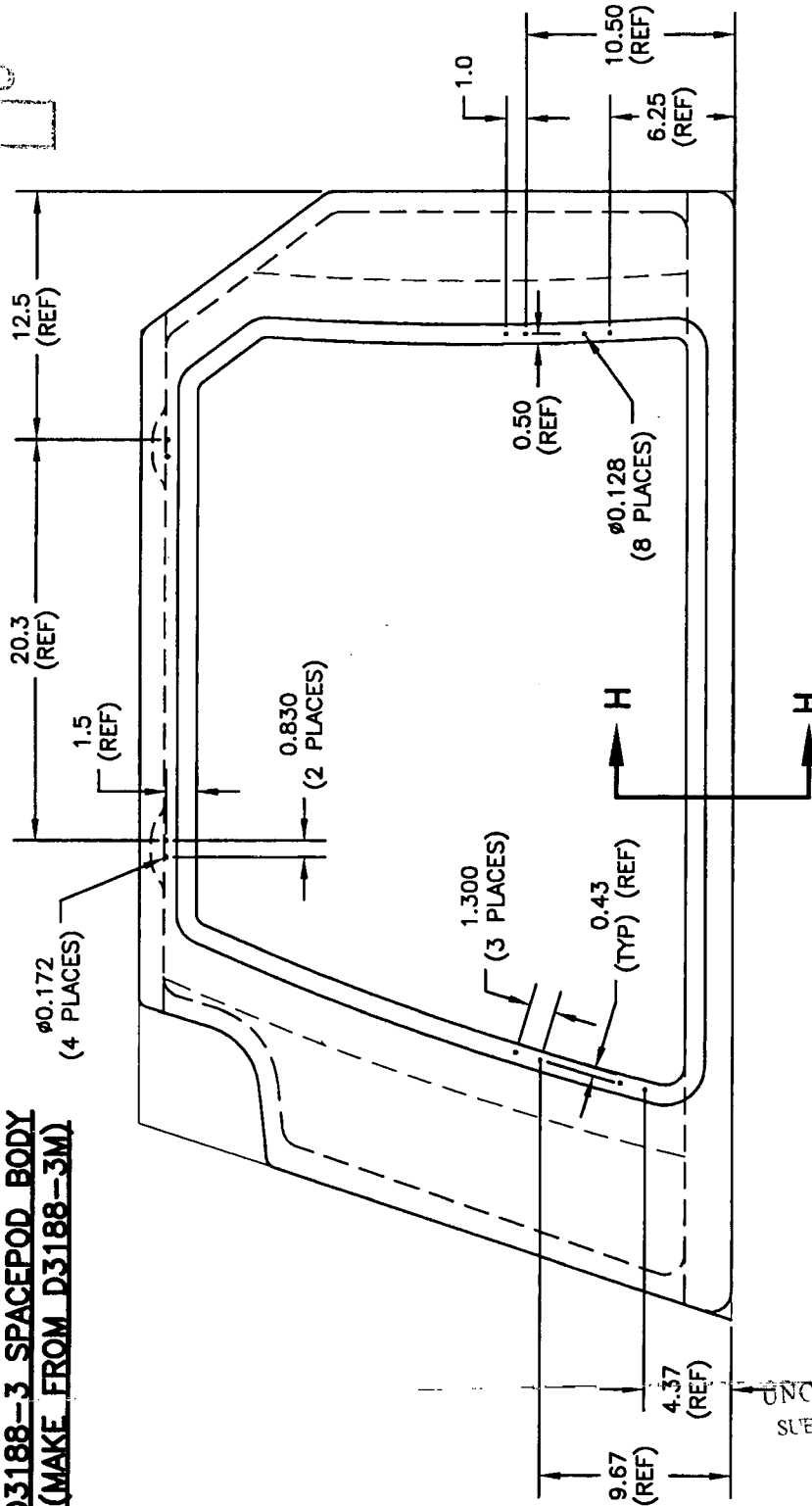
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07.02.27 [Signature]



D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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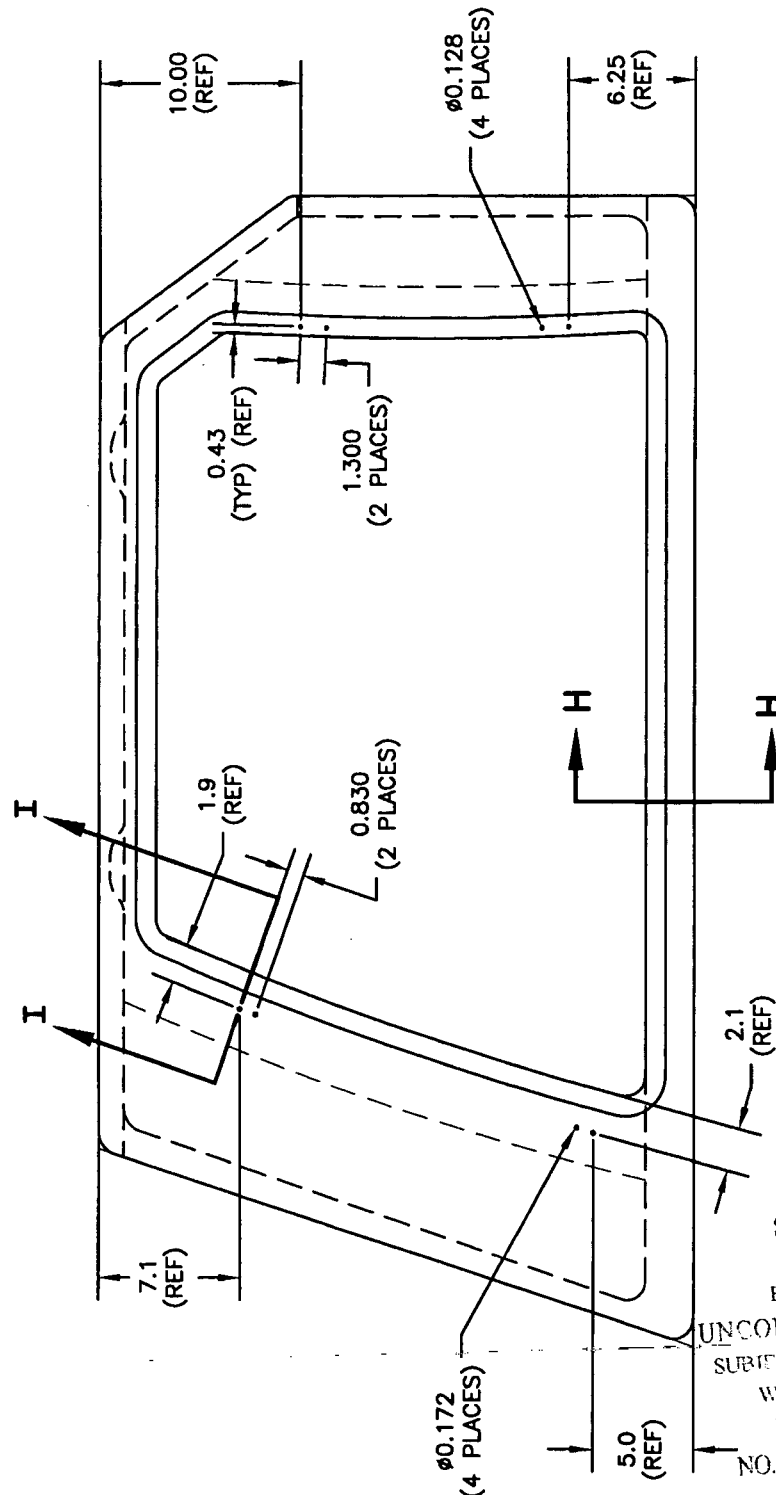
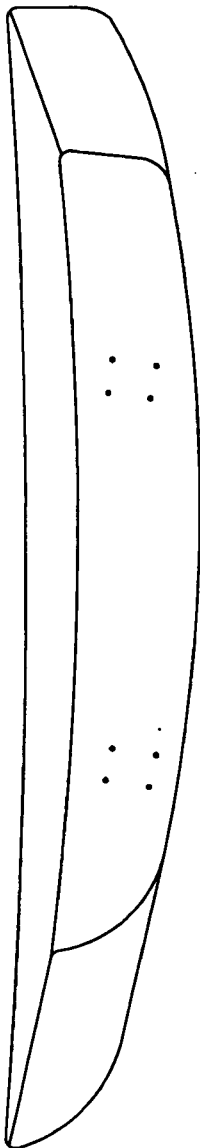


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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27 *[Signature]*

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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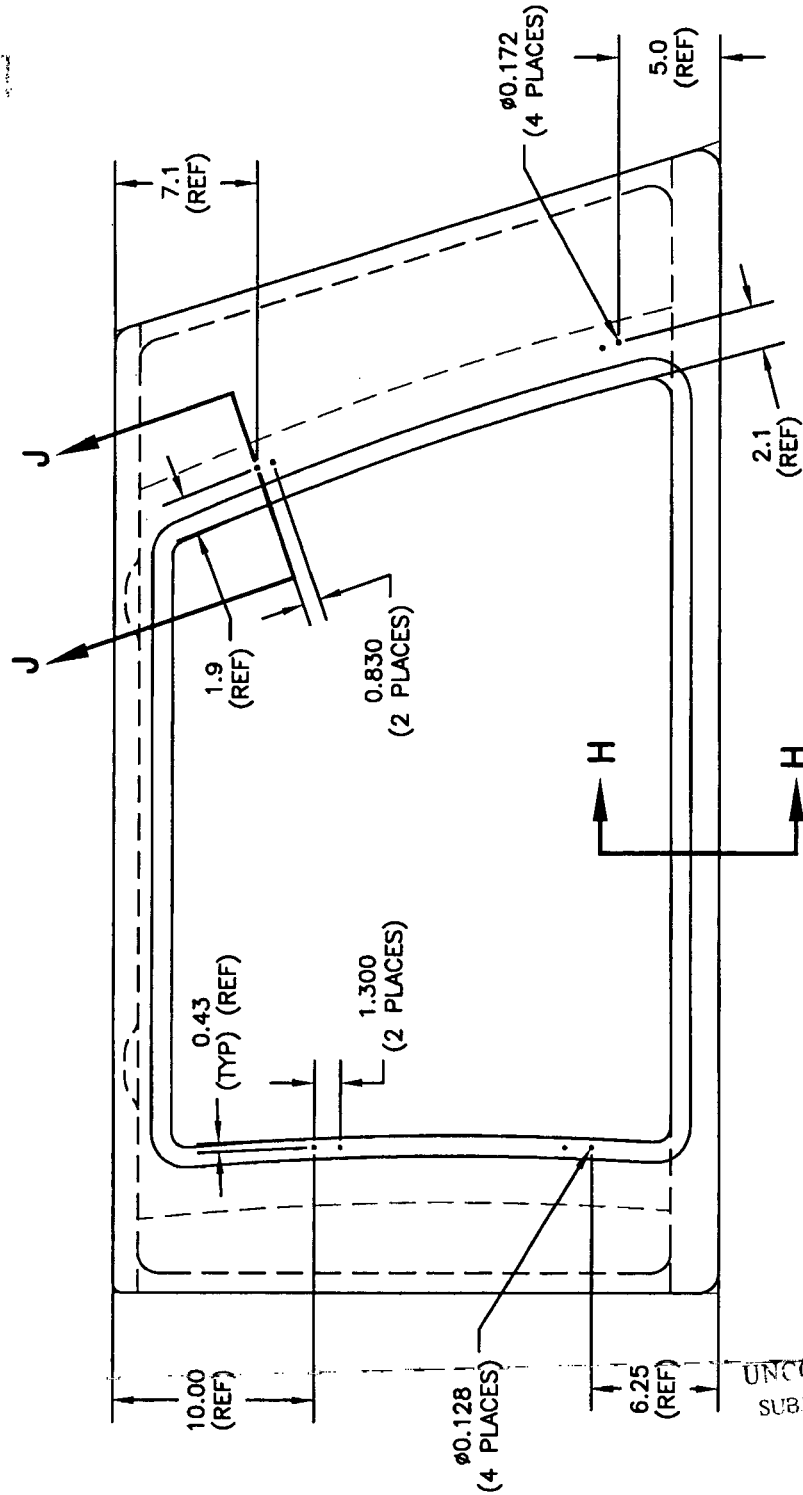
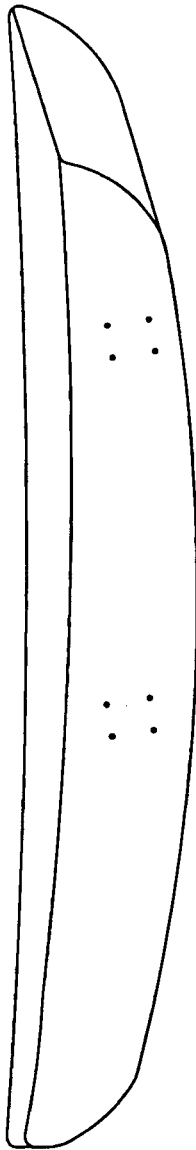
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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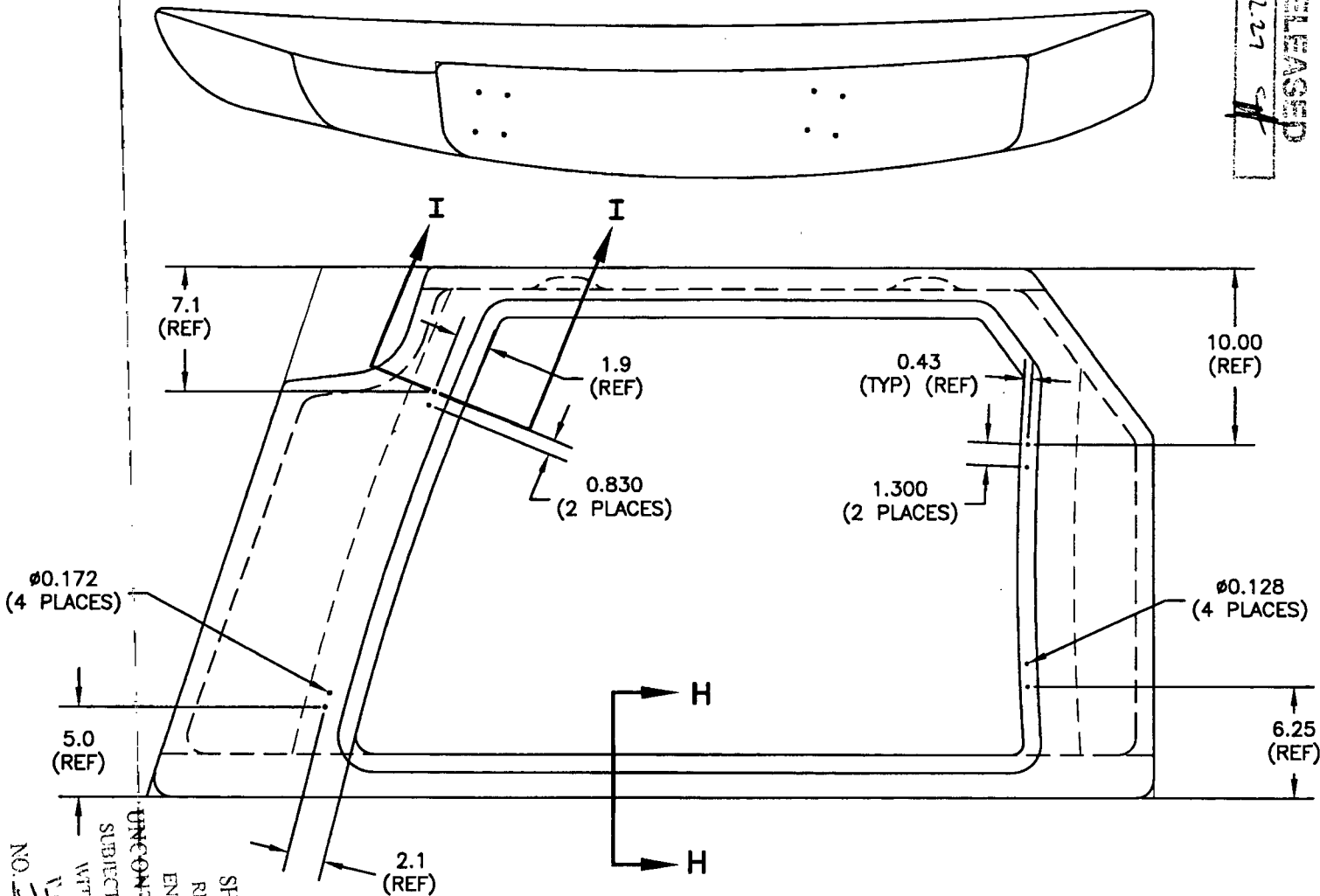
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CHECKED	JB	APPROVED	CE	HAWKESBURY, ONTARIO, CANADA	
DATE	07.02.22	DRAWING NO.	D3188		SHEET 10 OF 11
		TITLE	SPACEPOD BODY		SCALE
					NTS

RELEASED
07.02.22

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DART

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 11 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

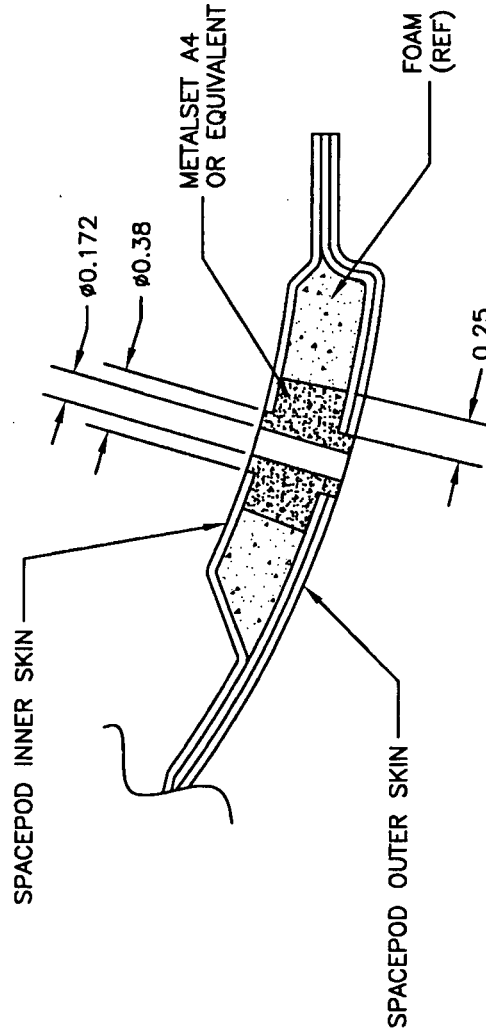
RELEASED

07.02.27 [Signature]

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)

SECTION H-H
(TYPICAL FLOOR SECTION)



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